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# SR SERIES
## User Manual

**Rev. 1.1**
**2015**

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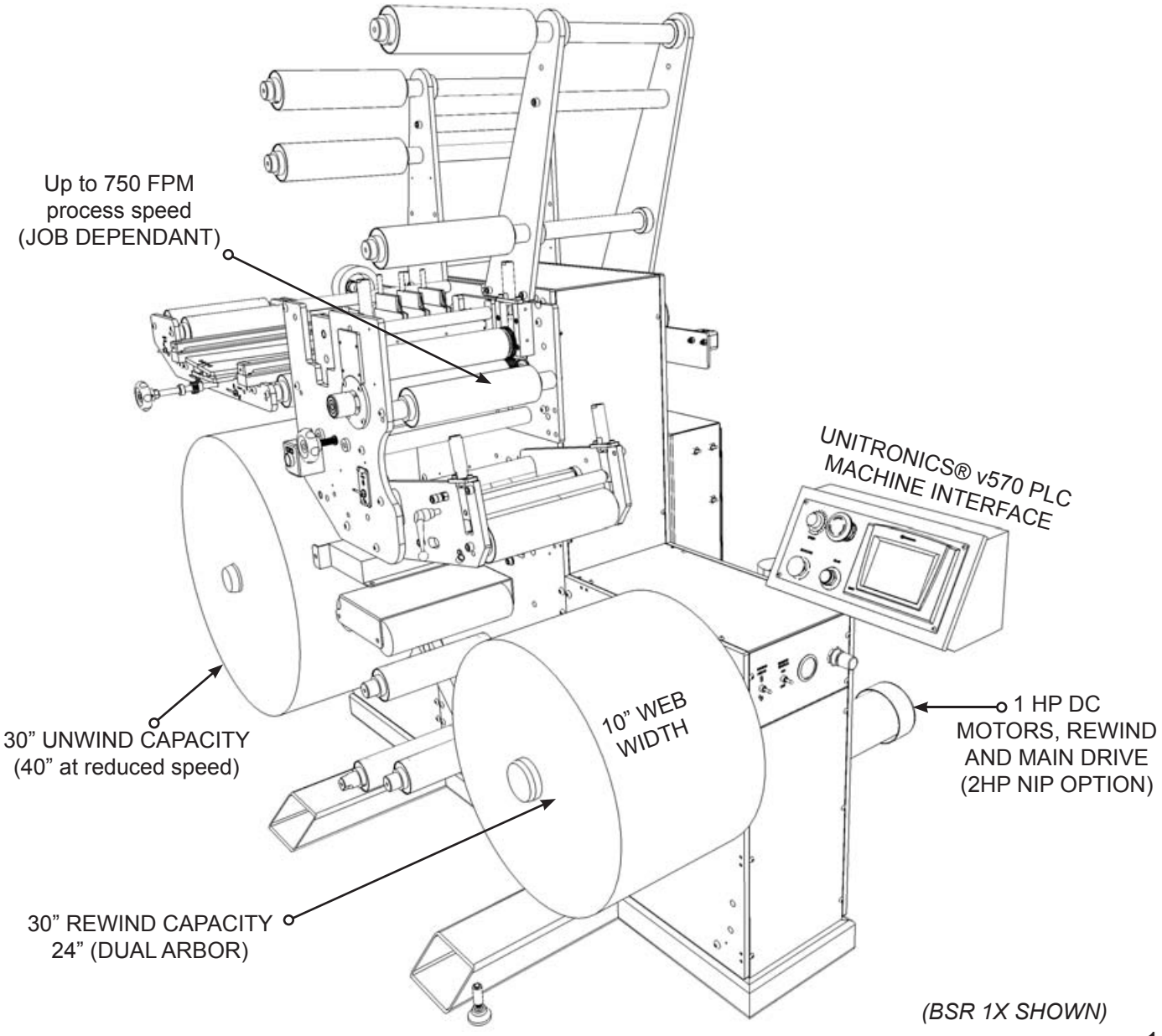
# Section 1: General Information

## 1-1: Introduction

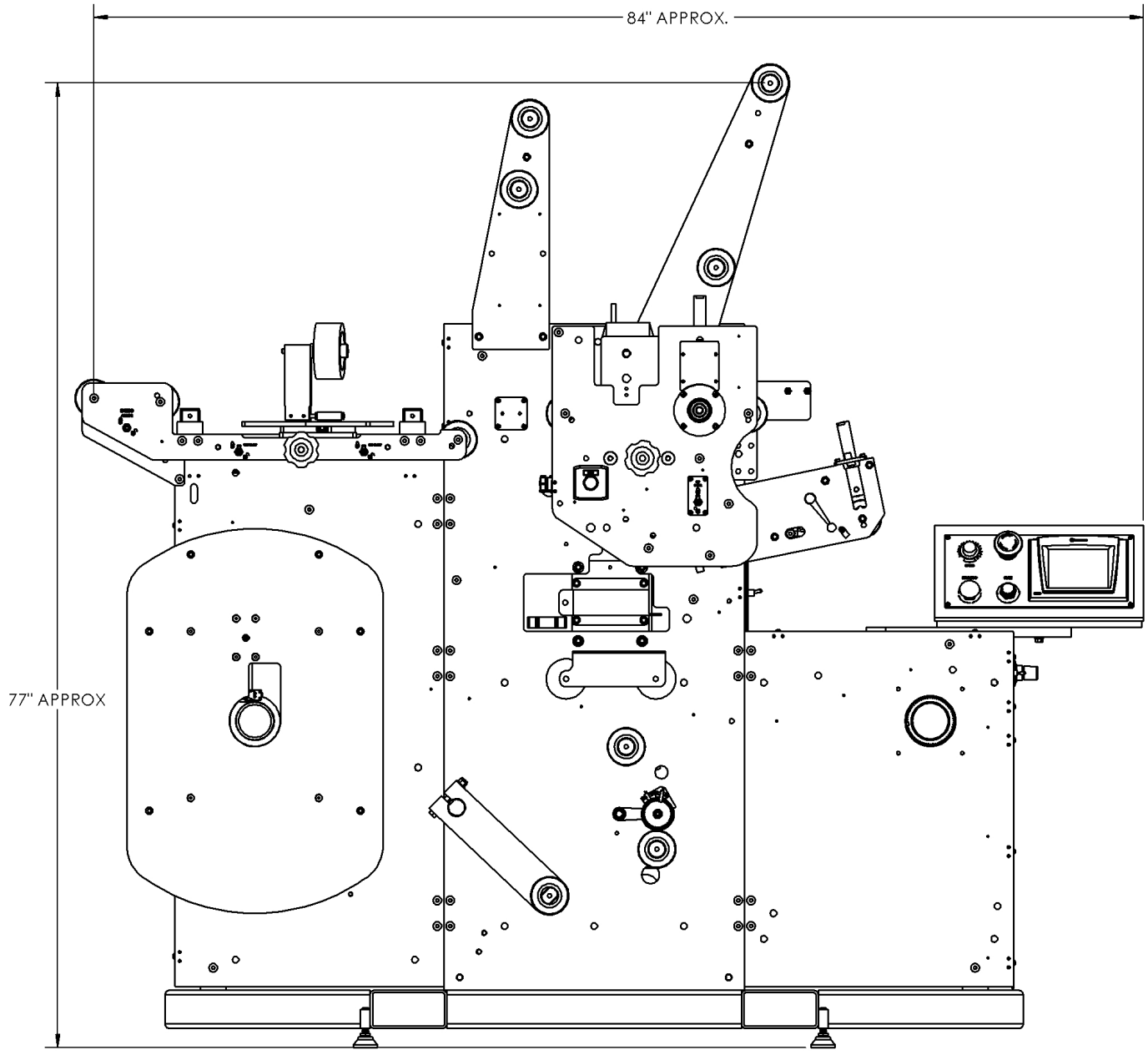
The AZTECH SR-Series Slitter/Rewind Inspector is available in 10 inch (25.4 cm), 13 inch (33.02 cm), 16 inch (40.64 cm), and 18 inch (45.72 cm) widths, and with either single or dual rewind spindles. The SR-Series is designed to be highly productive and versatile, and simple to operate, maintain, or repair with its electronic tension control and clutch-less design. Before operating your new SR-Series, fully read and understand this manual. Following the procedures outlined in this manual will help assure maximum performance. Keeping your machine properly set-up and maintained will assure years of productive and satisfactory service.

## 1-2: Machine Information and Specifications




*(BSR 1X SHOWN)*

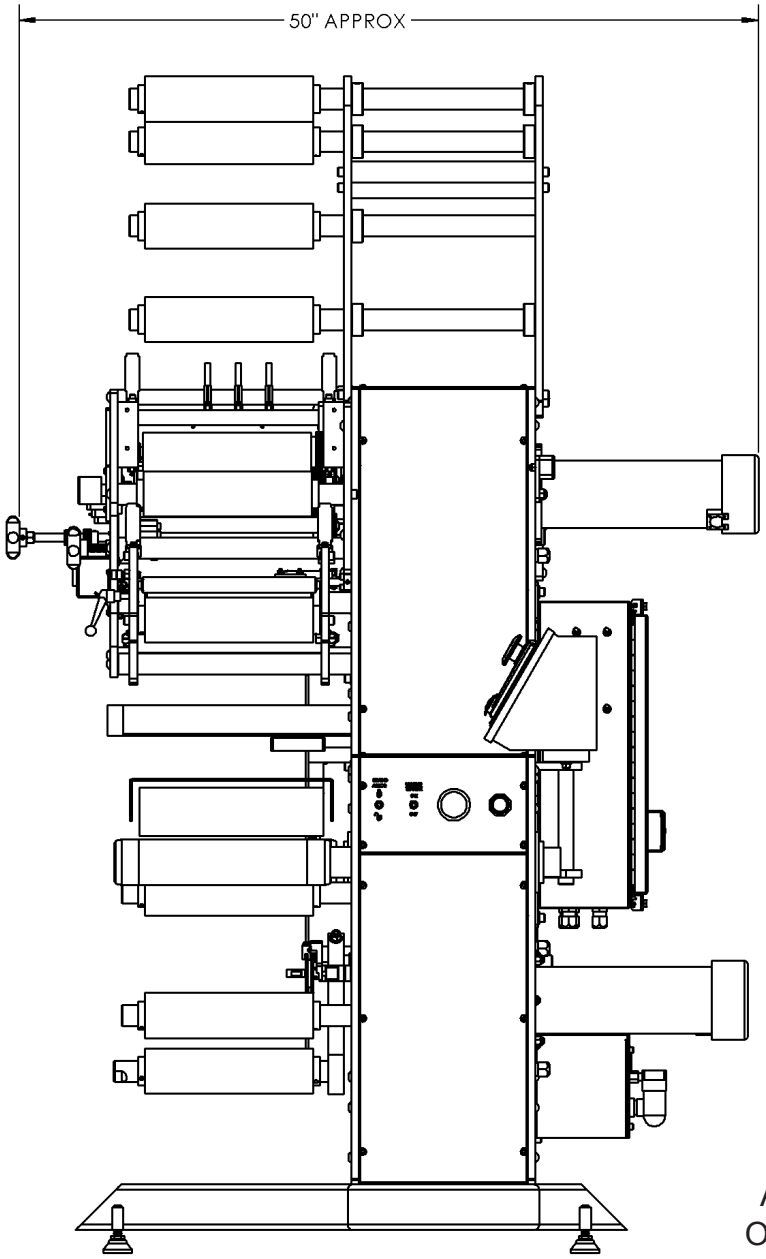
## FRONT LAYOUT




## BSR SINGLE ARBOR

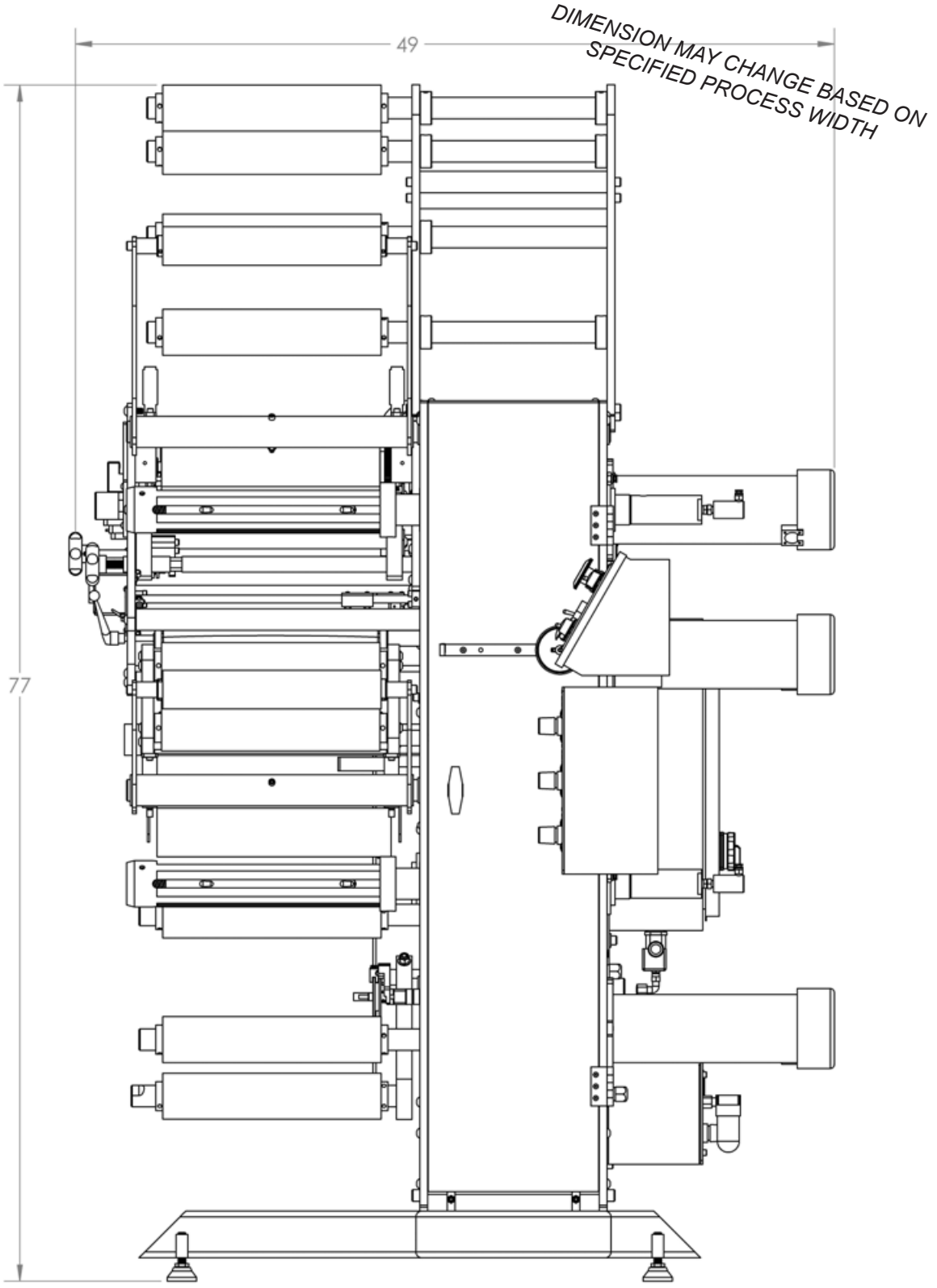
## SIDE LAYOUT

DIMENSION MAY CHANGE BASED ON SPECIFIED PROCESS WIDTH

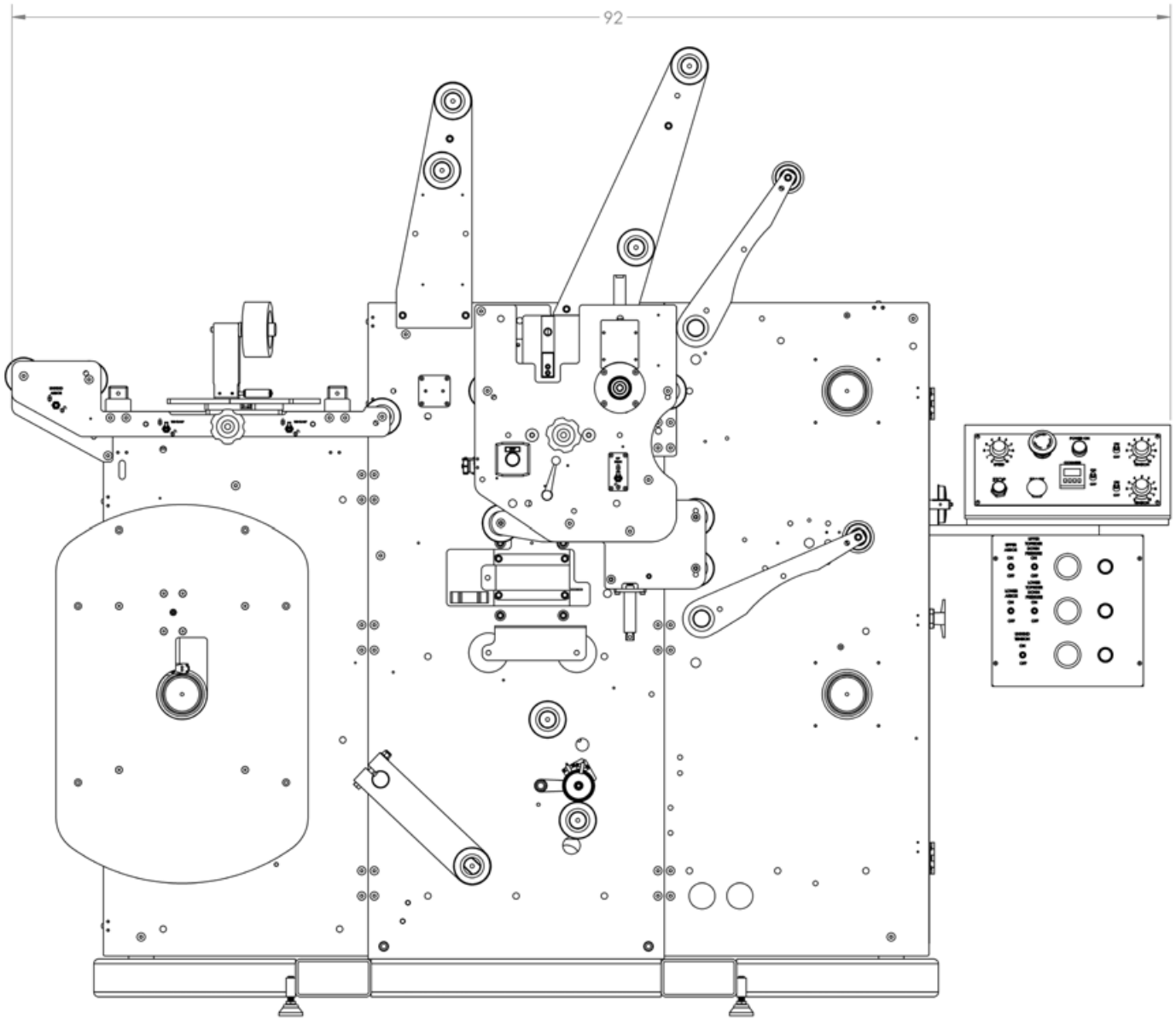



ALLOW AT LEAST 3 FEET
OF WORKING CLEARANCE
AROUND THE PERIMETER
OF THE MACHINE

## SIDE LAYOUT

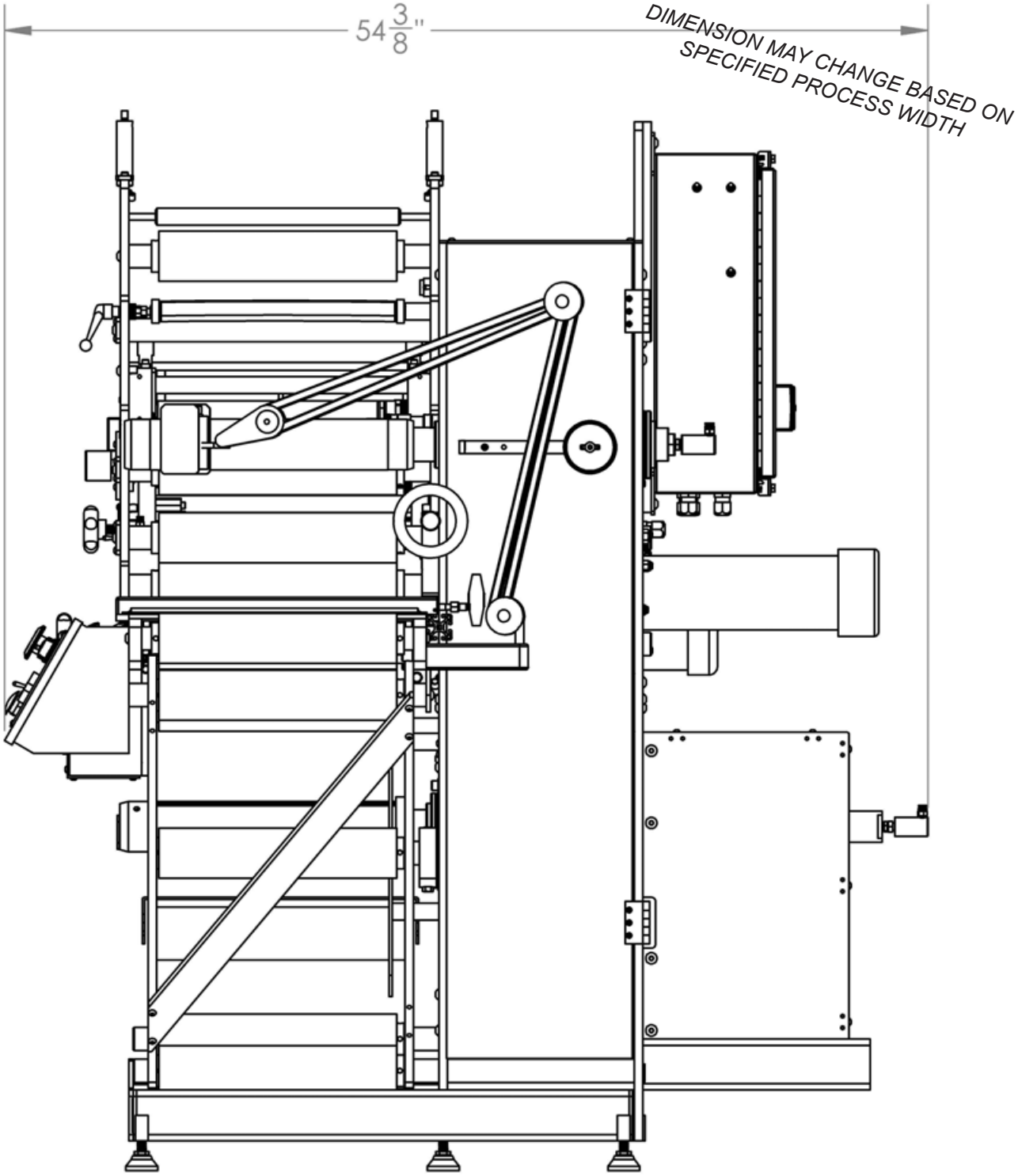

49
DIMENSION MAY CHANGE BASED ON
SPECIFIED PROCESS WIDTH
77

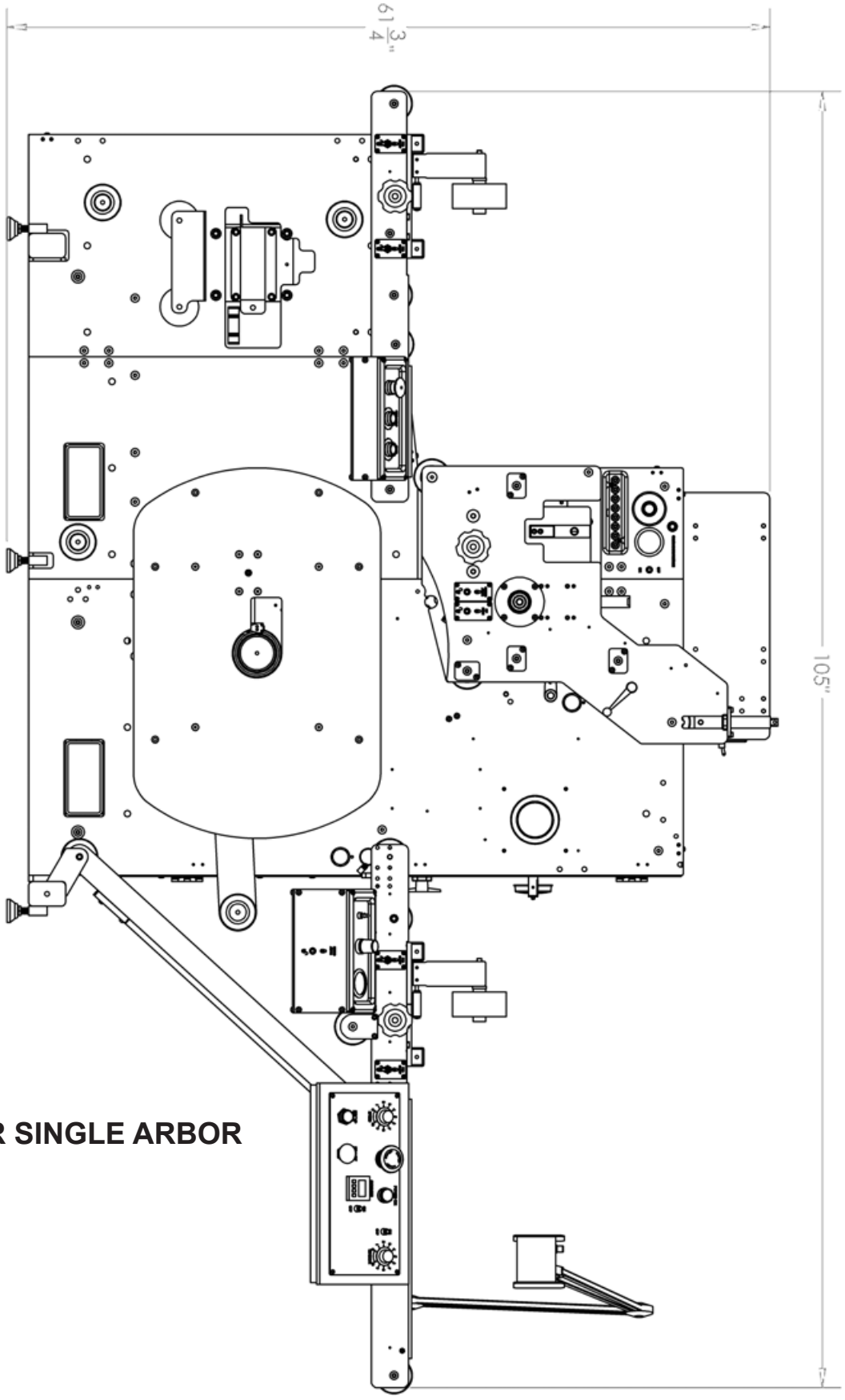
## FRONT LAYOUT




## BSR DUAL ARBOR

## SIDE LAYOUT

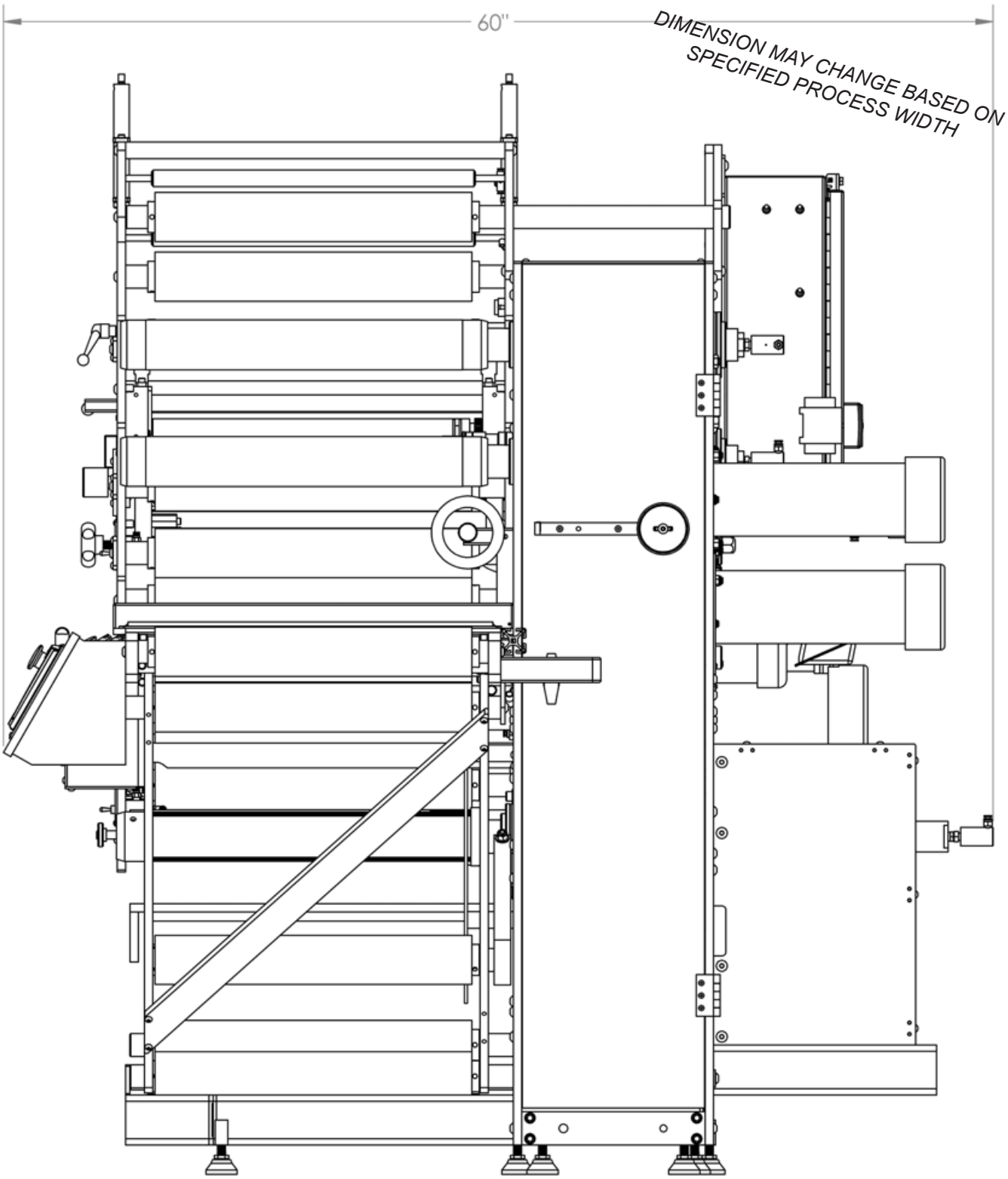

54 3/8"
DIMENSION MAY CHANGE BASED ON
SPECIFIED PROCESS WIDTH



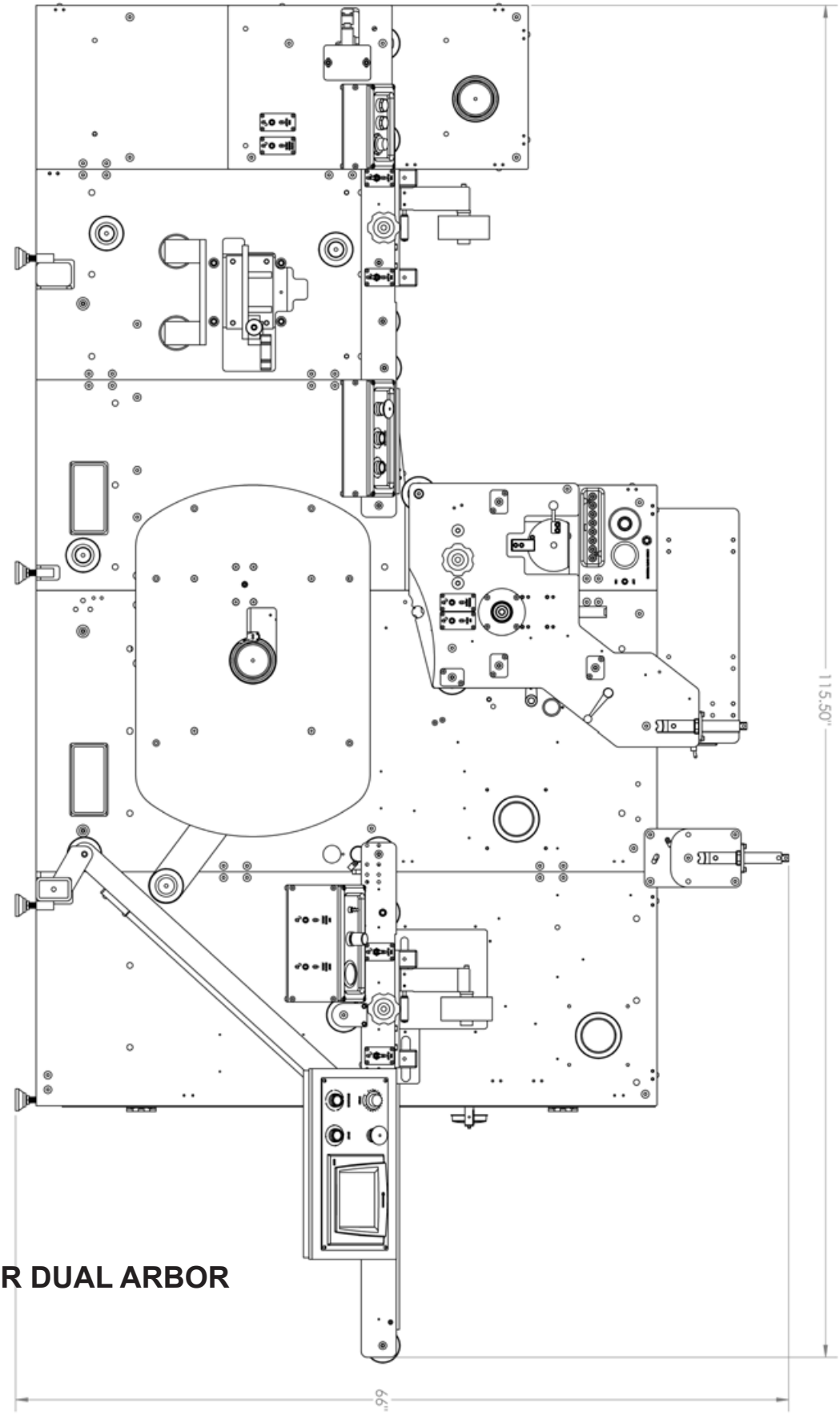

## ISR SINGLE ARBOR

## FRONT LAYOUT

## SIDE LAYOUT



FRONT LAYOUT




ISR DUAL ARBOR

**1-4: Safety**

The SR-Series Slitter/Rewinder is designed to operate at high rates of speed, employing rollers, gears, pulleys, and other moving parts. Where possible, guards are provided to protect operator from injury. Operators must keep their hands clear of the machine when it is in operation. Making all operators aware of potential safety hazards will help minimize any chances of operator injury.

## Section 2: Machine Installation

**2-1: Preparation**

It is important that your SR-Series Slitter/Rewinder be situated on solid and level ground. Make sure that site allows for access to machine from all 4 sides. If the machine is placed on unstable or un-level ground, it may tip over risking damage or serious personal injury.

**2-2: Un-crating Machine**

To avoid damage to your new SR-Series Slitter/Rewinder, first remove the cover by removing all screws, then remove one of the 2 long side panels to expose machine. Remove all 4 lag bolts which hold the machine to the base. Remove all boxes and parts inside crate.

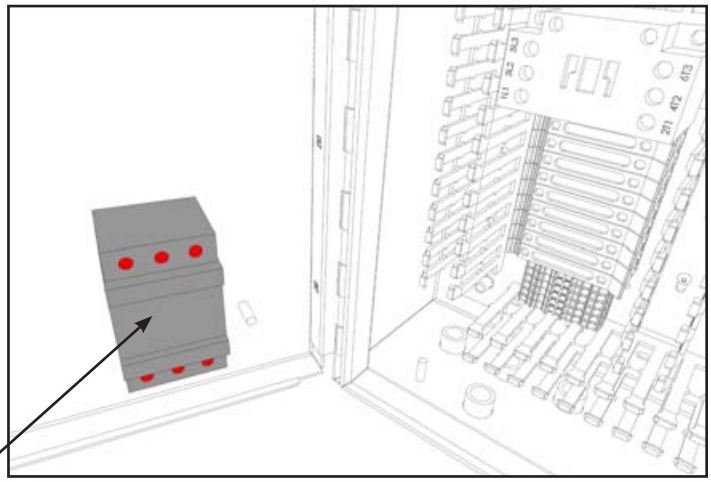
**2-3: Removal and Positioning**

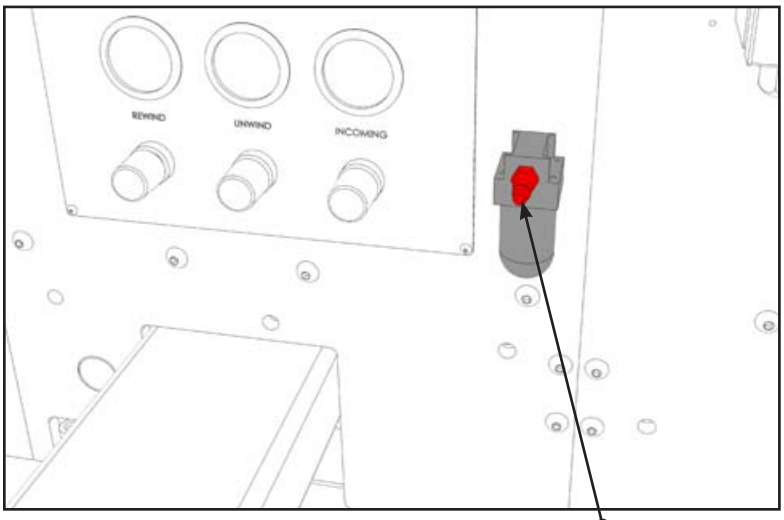
It is critical that the SR-Series Slitter/Rewinder be removed from the crate using a fork lift, making sure that the forks fit directly inside the 2 slots at base of the machine. Lift and remove from crate, and if equipped with adjustable feet, thread all 4 feet into threaded holes at machine's base, and lower into desired position. Machine may be leveled by turning adjustable feet until level.

**2-4: Electrical and Pneumatic Connections**

*ELECTRICAL CONNECTIONS:* Your SR-Series Slitter/Rewinder uses a power supply of 220 volts, 20 amps AC. Improper connections or mishandling may cause serious personal injury. AZTECH highly recommends that electrical service be performed only by a qualified electrician.

Electrical connection to the machine is performed by bringing electrical service to the electrical box at the back of the machine and making connections as shown.






90PSI INCOMING HP AIR

PNEUMATIC CONNECTIONS: Although your machine has been thoroughly tested before shipment, connections on occasion may loosen during shipment. Visually inspect all pneumatic to assure that each is fitted securely. Connect airline to the pneumatic control panel at the back of the machine (see figure 2-B), and listen for any air leaks that may exist. Check all switches by switching back and forth from on and off to make sure they are operating properly.

**NOTE: Red lines on air dials indicate proper default settings.**

### 2-5: Testing Before Operation

Make sure the area around your machine is clear of any objects which may impair the machine. Also inspect and make sure all belts, pulleys, rollers, and spindles are free and clear of any objects which may impede operation, and risk machine damage. Before threading your machine, accelerate and decelerate your machine through a full range of speeds, and make sure acceleration is smooth and free of any unnatural sounds or movements. Using control switches, switch Unwind and Rewind Spindle(s) from on and off positions making sure the pneumatic system is performing properly. Then turn power on, run machine at low speed to assure machine is working properly. Then with speed set at maximum setting, press the stop button to assure that the brake is working properly.

## Section 3: Machine Setup

### 3-1 Webbing the Machine

Proper webbing of your SR-Series Slitter/Rewinder is vital to optimal machine performance. The following pages illustrate the proper ways to thread your machine for various substrates. Any improper webbing of the machine may cause tension problems that will impede operation.

**To web the machine:**

1. Turn unwind arbor switch to “DEFLATE” position.

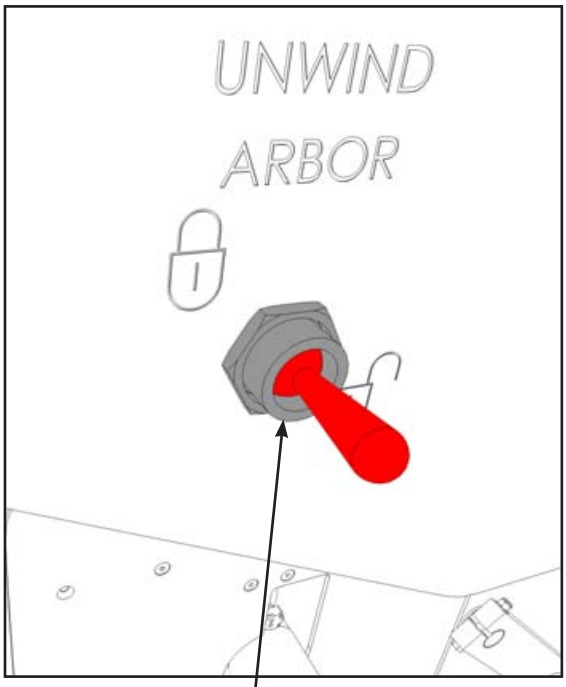
2. Assure that the rewind and unwind switches on main panel are in the “OFF” position

3. Assure that both splice-table clamps are released into the up position.

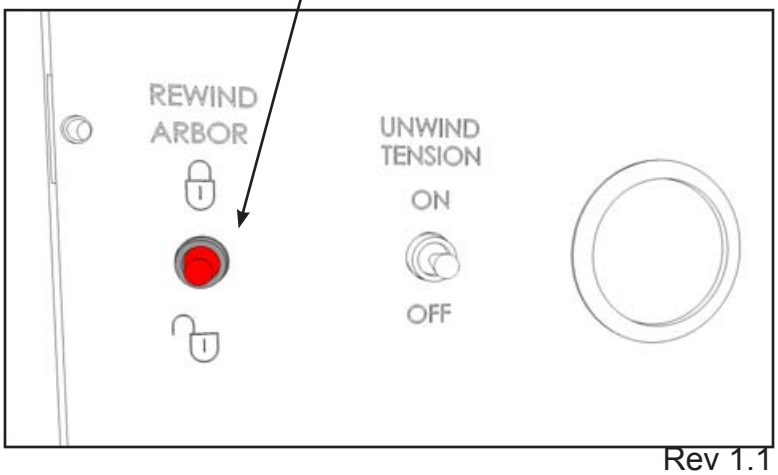
4. Assure that the pneumatic nip roll is disengaged in the up position.

5. Assure that the slitting blades are disengaged. **BE SURE TO USE CAUTION WHEN NEAR SLITTING BLADES AS THEY ARE EXTREMELY SHARP AND MAY CAUSE SERIOUS INJURY.**

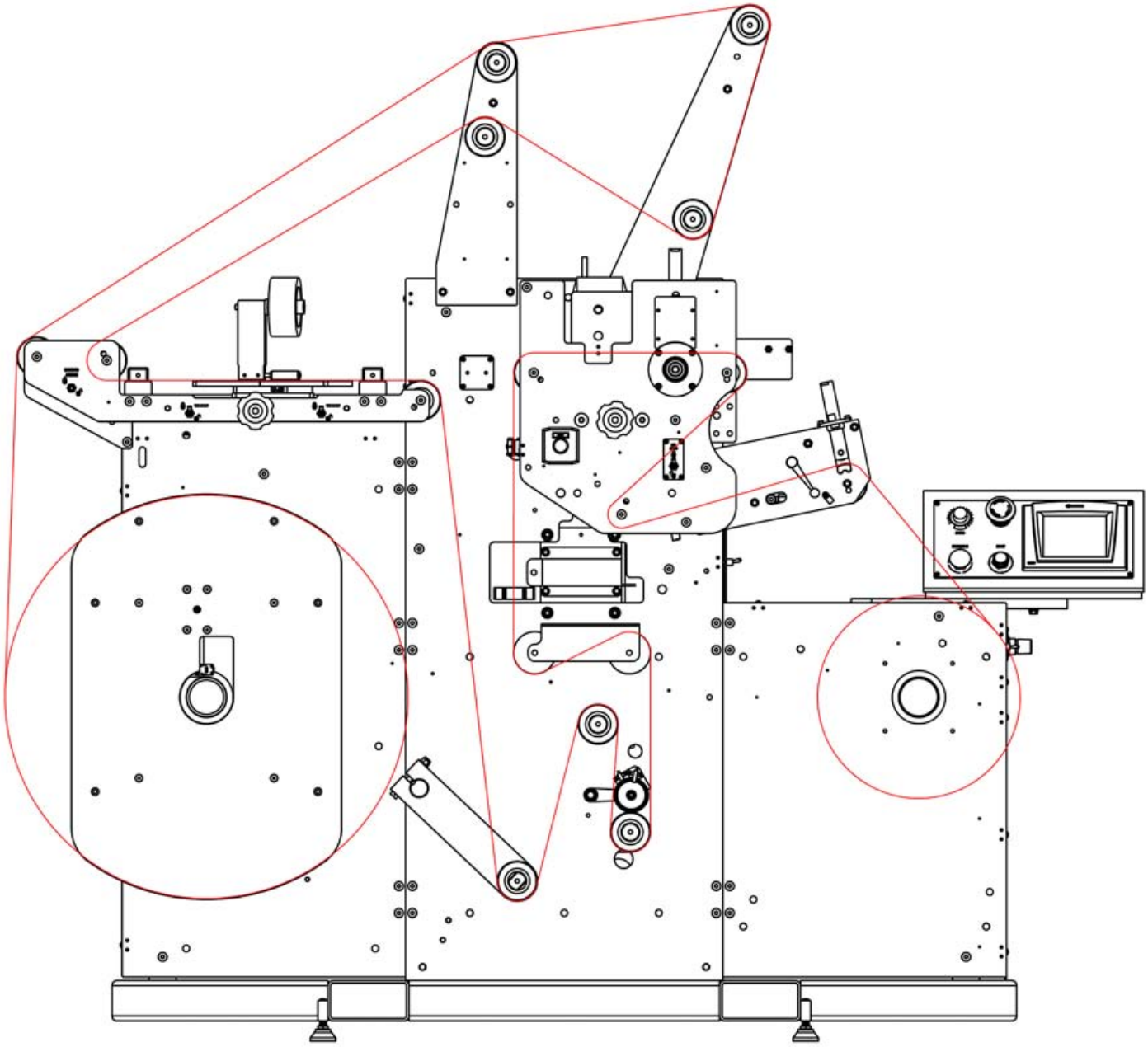
6. Load roll onto unwind spindle and carefully thread the web through the machine making sure to follow web paths on the following page.




ARBOR LOCK SWITCHES



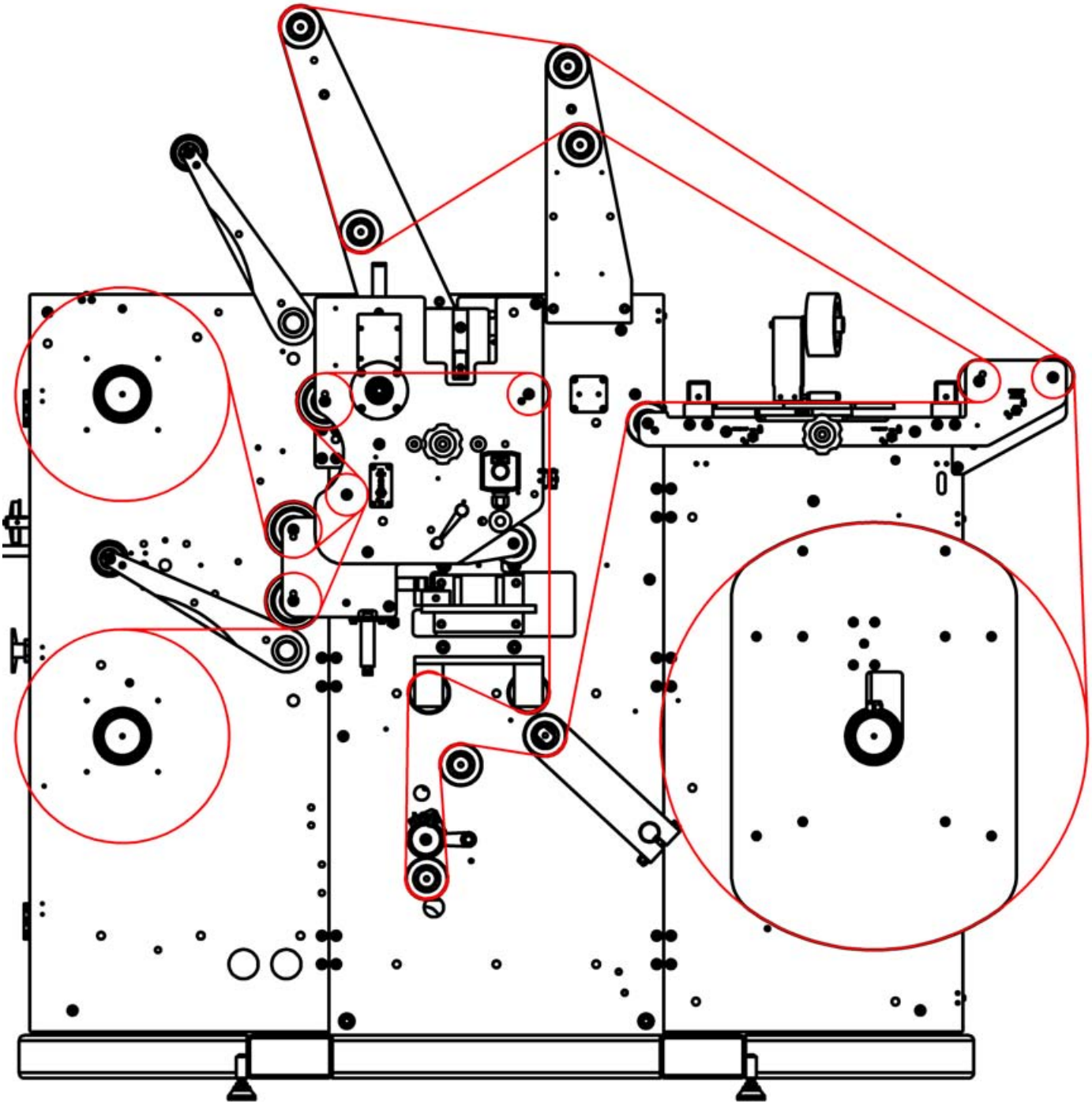
## SR Series Web Path(s)



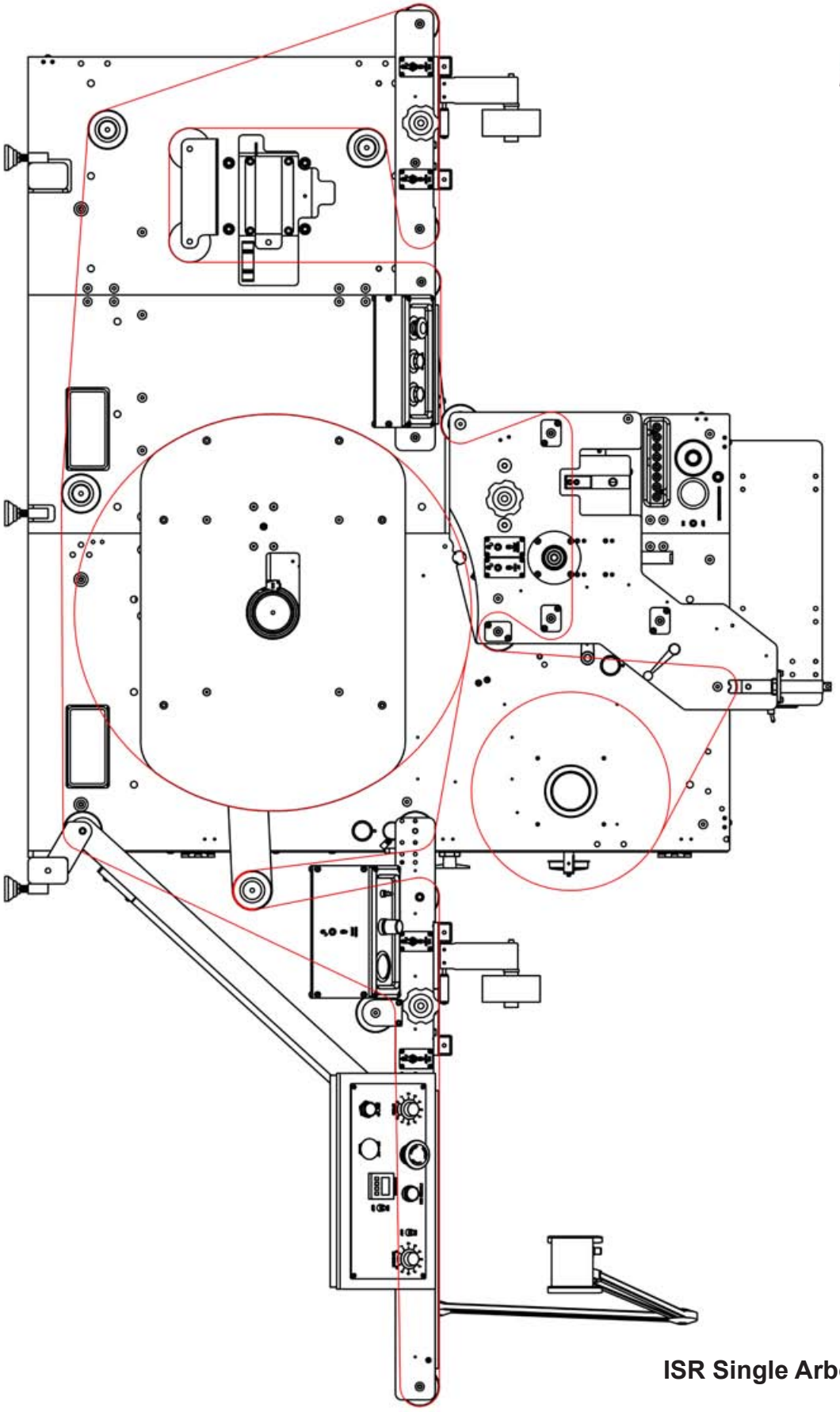
**BSR Single Arbor**

Proper webbing of your SR-Series Inspection Rewinder is vital to optimal machine performance. Any improper webbing of the machine may cause tension problems that will impede operation.

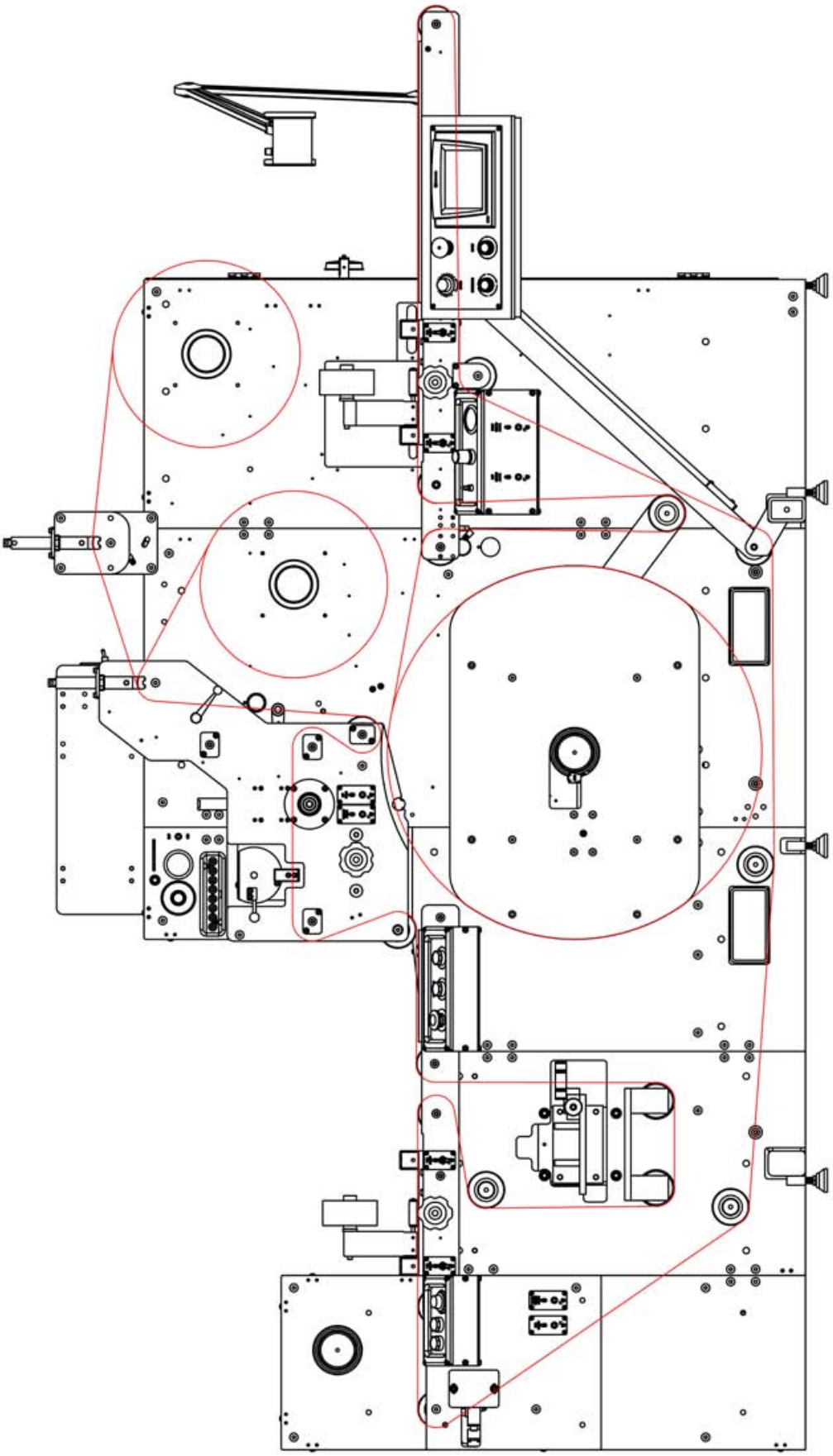
*NOTE: Web paths are shown in OVERWIND configuration and through optional inspection towers.*



**BSR Dual Arbor**



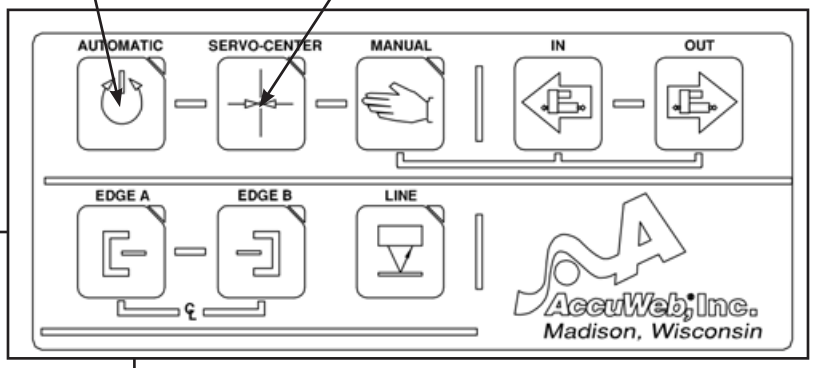
ISR Single Arbor

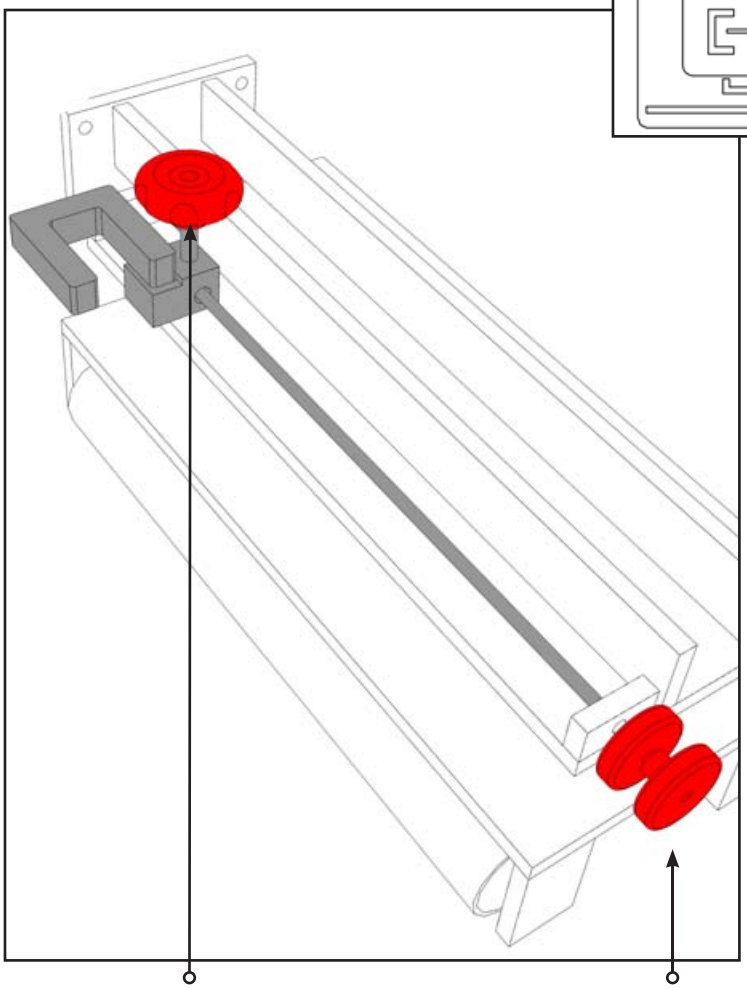


**ISR Dual Arbor**

### 3-2 Web Guide Setup

The web guide is located in the center of the machine between the unwind and re-wind stations. After webbing the machine, set the web by doing the following:



COARSE SENSOR POSITIONING

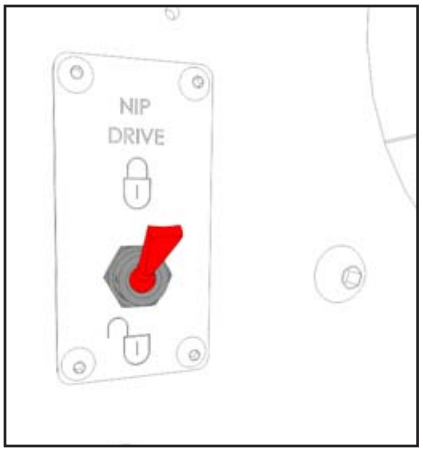
FINE SENSOR POSITIONING

**Setting the Web Guide:**

1. Press the “SERVO-CENTER” button on the front of the web guide.
2. Align the sensor with the inside edge of the web. For fine alignment adjustment, turn knob on outside of web guide.
3. Jog the machine briefly to assure that the web is moving smoothly.
4. Press the “AUTOMATIC” button which will engage the sensor and allow the web guide to adjust itself to the movement of the web.
5. For more specific instructions about the features of the web guide, refer to the Ac-cu-Web manual included with this manual.

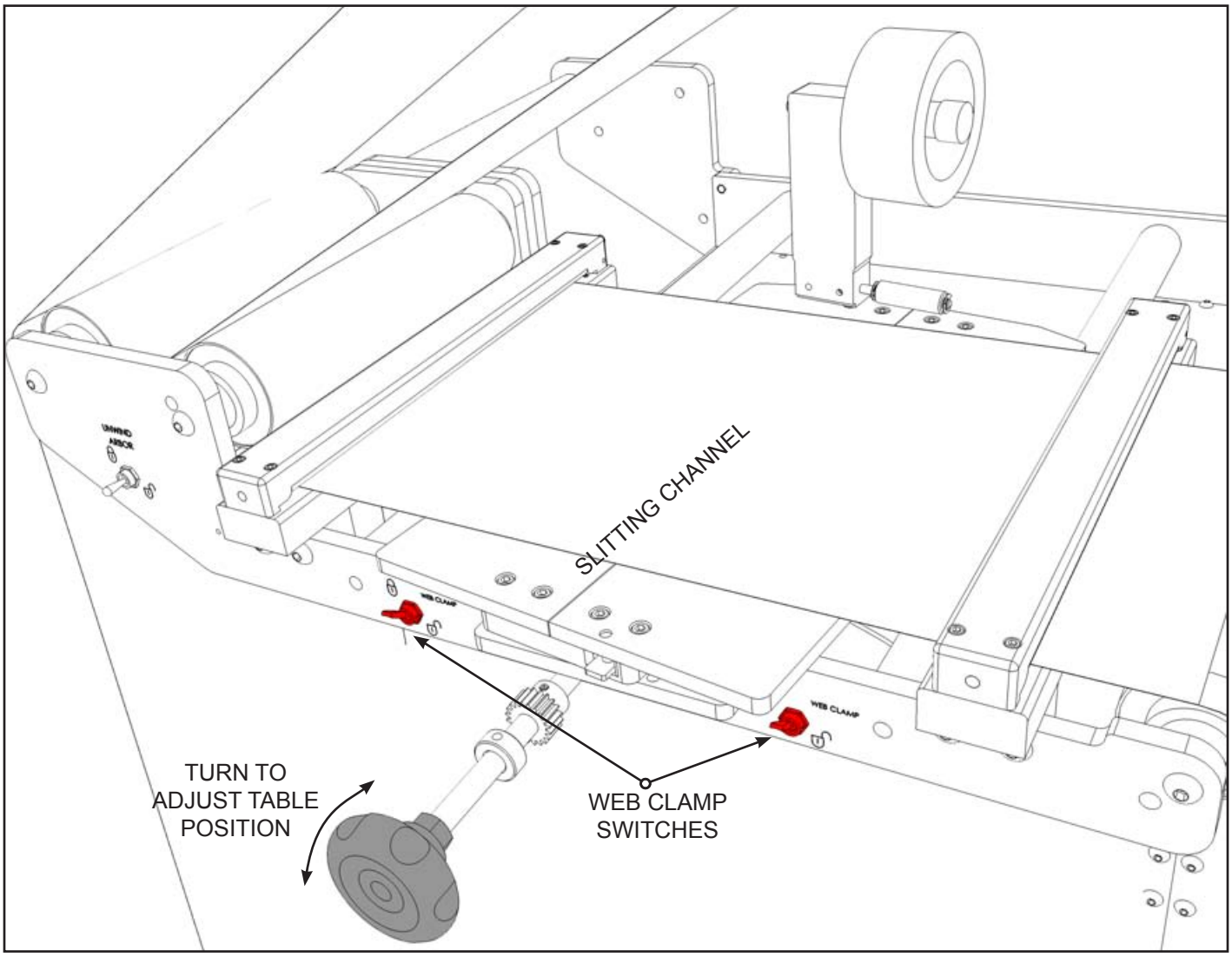
### 3-3 Nip Roll Operation

The Nip Roll is pneumatically controlled using control switch (see figure 3-E) and must be in the down position while machine is running, and in the up position when threading machine.

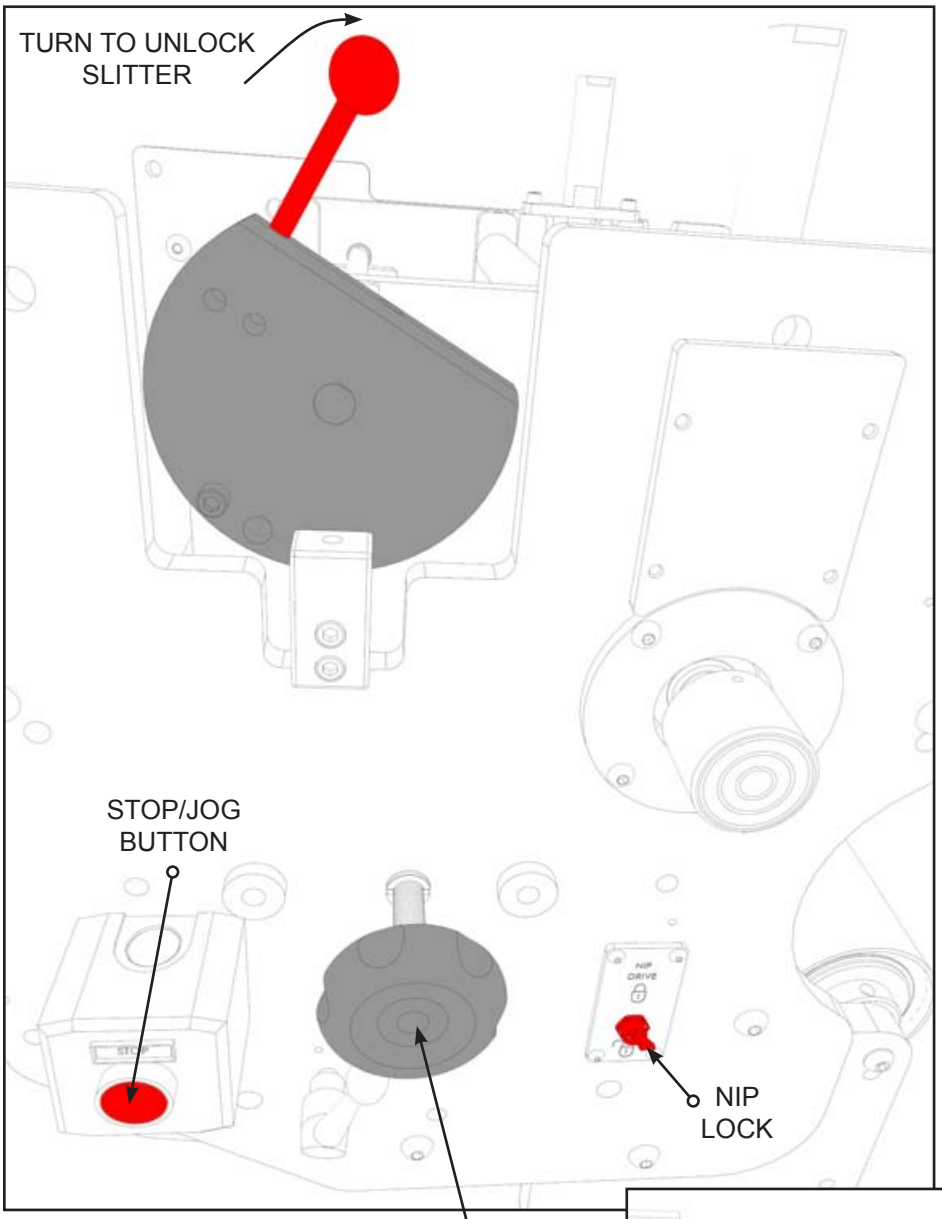


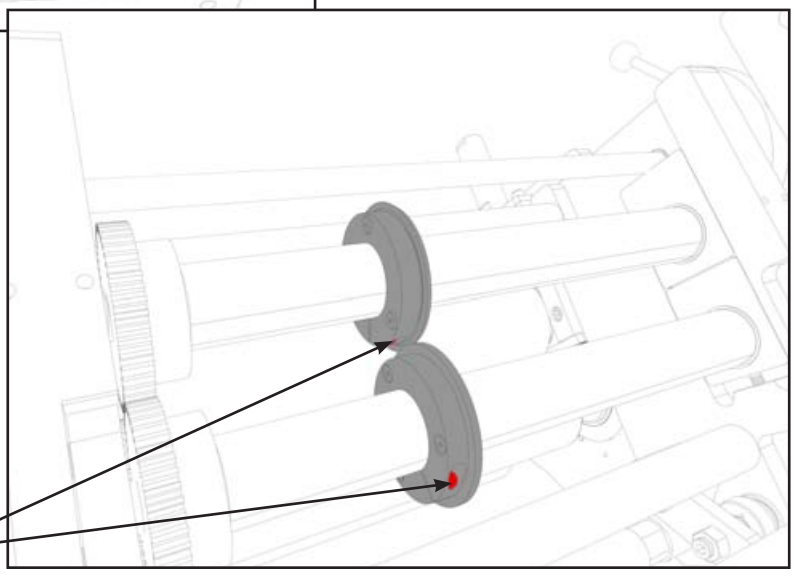
### 3-4: Splice Table Operation

The splice table on your SR-Series  is located just above the Unwind Station, just after the optional Inspection Tower. To operate the Splice Table, simply follow the following steps:




1. Turn off machine and engage both web clamp switches.
2. Using a razor blade, carefully cut the web along the slicing channel. Disengage the clamp nearest the unwind station. Be sure to leave the other clamp engaged.
3. After waste has been removed, pull through new web, carefully align with web, and lower the handle to hold.
4. Again using a razor blade, cut the web, discard waste, pull tape under webs, fold to secure and cut tape.
5. Disengage both switches to release web clamps.



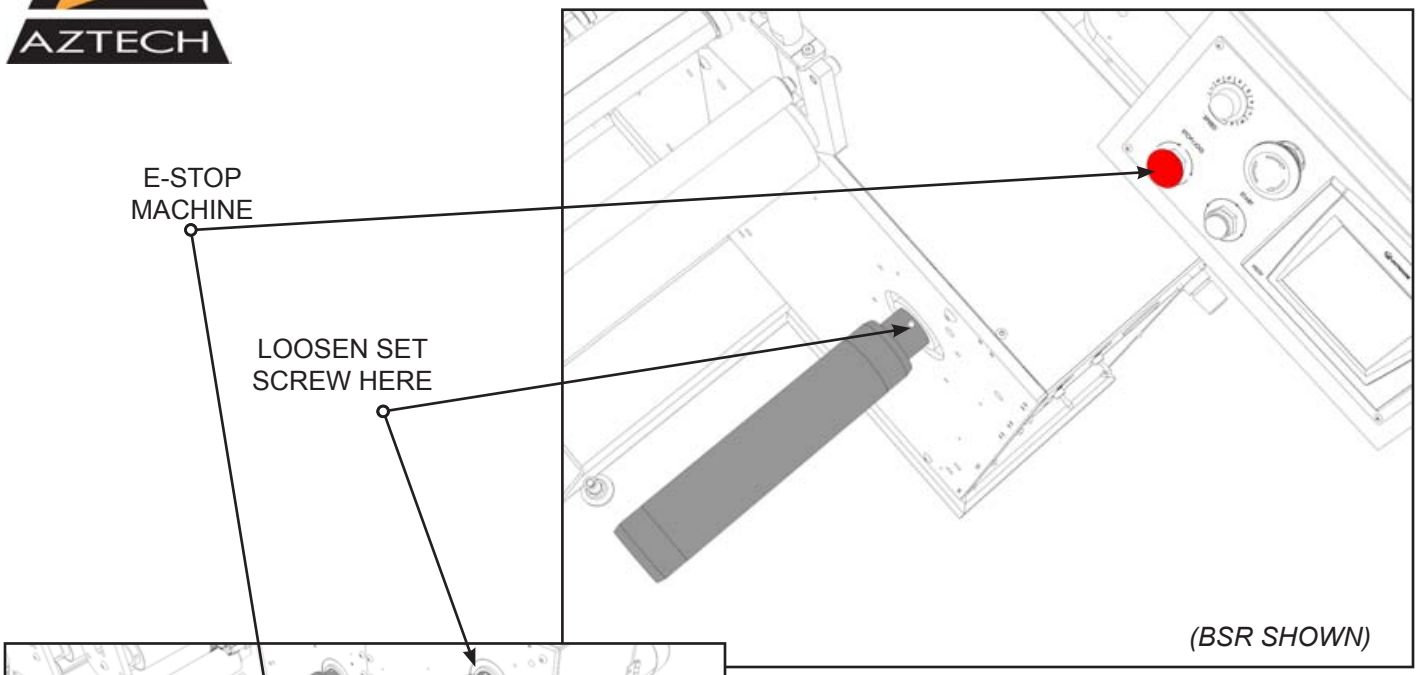



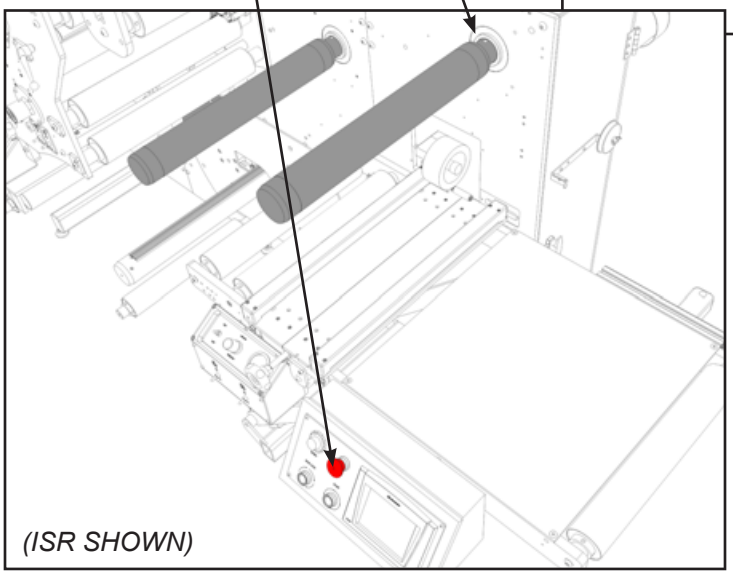

## 3-5: ROTARY SHEAR SET-UP

**Step 1** Set lower blades for desired Slit-widths and tighten set-screws, making sure upper blades are up and not in lock position.

**Step 2** Lower upper blade assembly by turning handle counter-clockwise and snap into lock position, making sure that the upper blades are clear of lower blades to avoid blade damage.

**Step 3** Gently slide upper blade(s) into cutting position flush against the lower blade(s) by pushing on both sides of the blade to avoid wobble. Hold upper blade against lower blade and tighten set-screw.



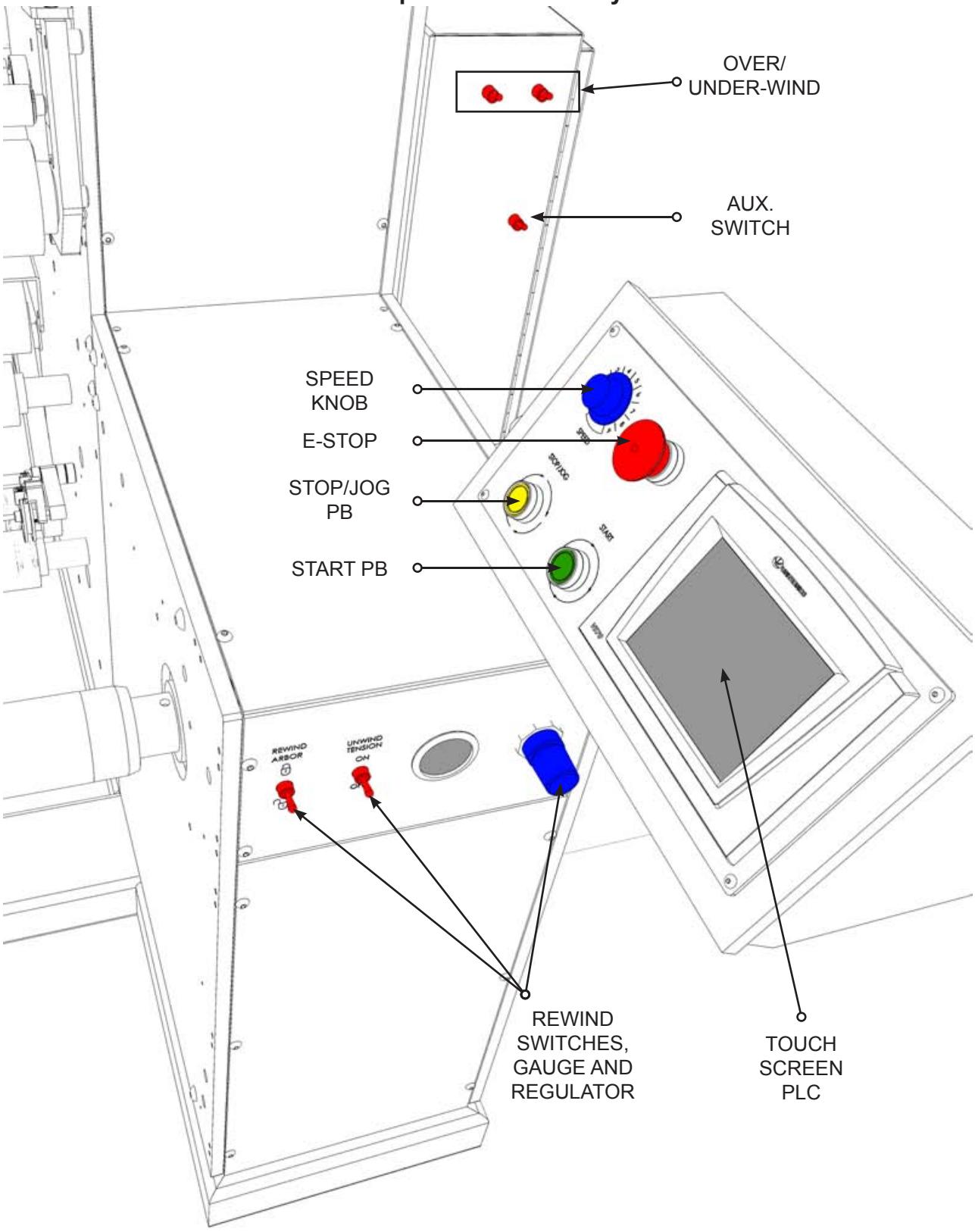

### 3-6: Changing Rewind Spindle

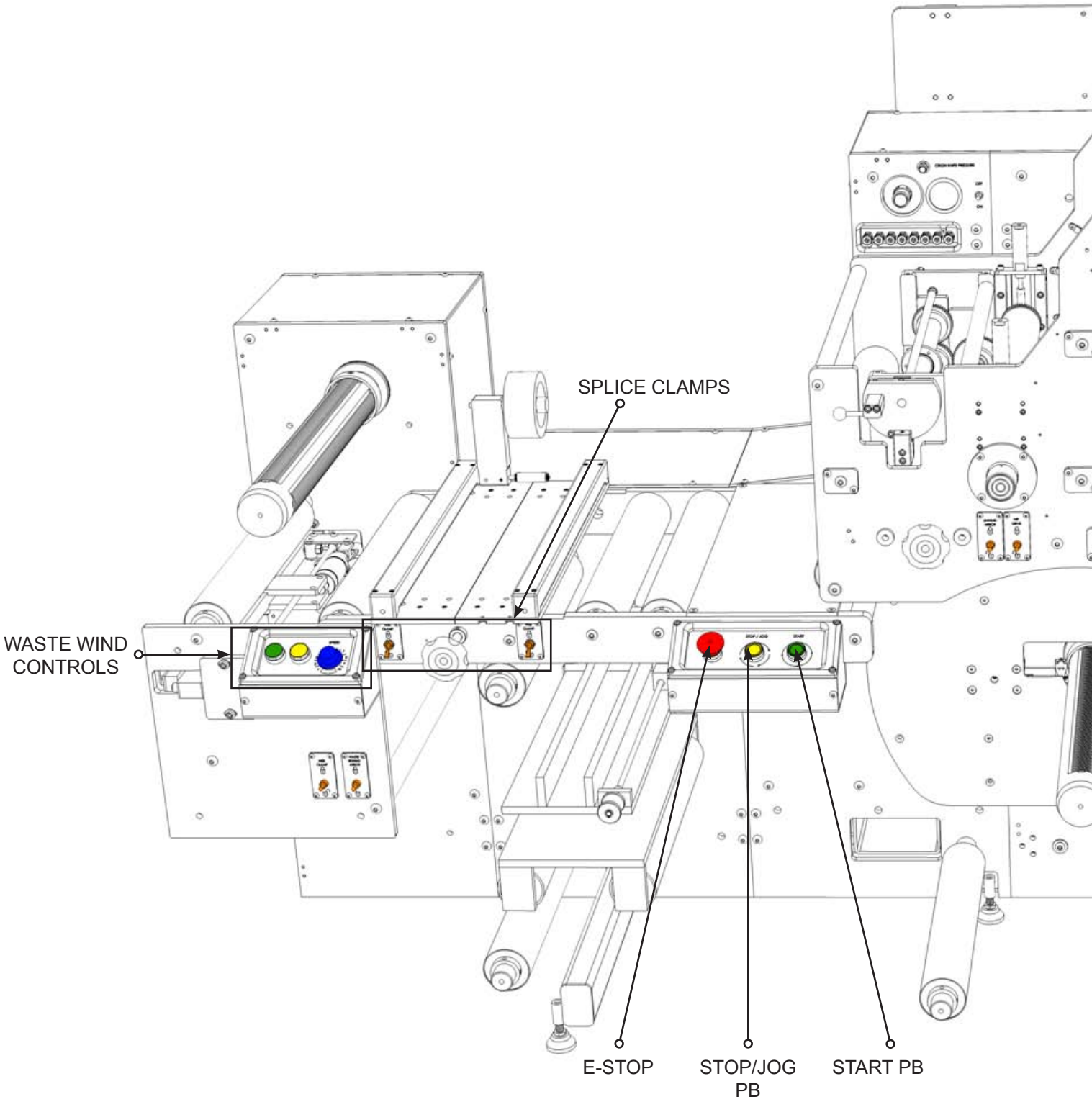
Your SR-Series Slitter/Rewind Inspector is equipped with Convertech pneumatically inflatable rewind spindles. These spindles are easily removed by loosening the hex-screw at the machine side and pulling away from machine. To insert new spindle, simply insert spindle into rewind station and tighten hex-screw firmly.

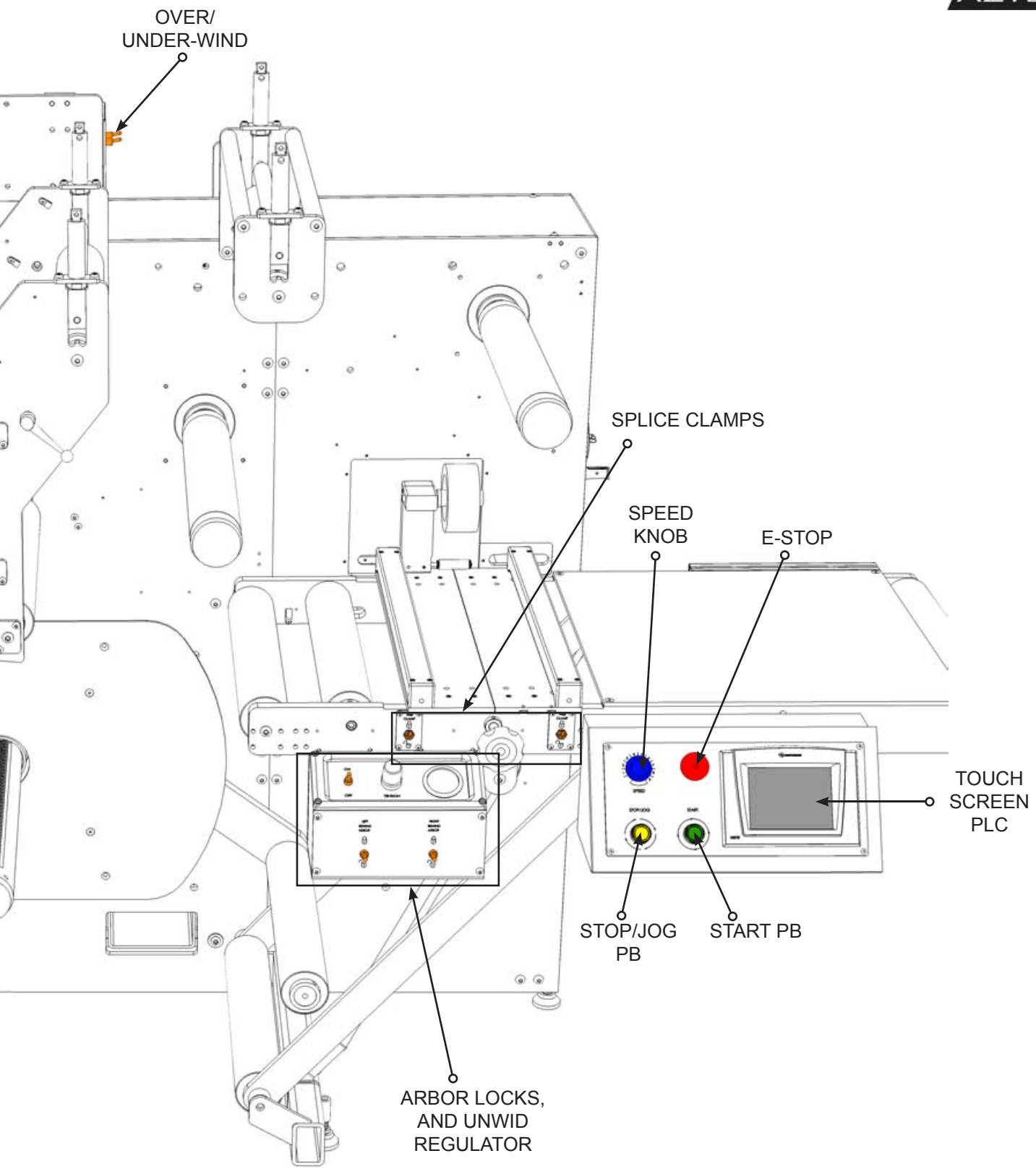
**CAUTION: Utilizing Rewind Spindles less than 1.5” in diameter require the use of Outboard Support Apparatus which is NOT included in the standard equipment. Operating the machine without the support apparatus and with spindles less than 1.5” may result in serious injury.**

## Section 4: Machine Operation

### 4-1 Operator Control Layout




SPLICE CLAMPS
WASTE WIND CONTROLS
E-STOP
STOP/JOG PB
START PB


OVER/
UNDER-WIND
SPLICE CLAMPS
SPEED
KNOB
E-STOP
TOUCH
SCREEN
PLC
STOP/JOG
PB
START PB
ARBOR LOCKS,
AND UNWID
REGULATOR

## 4-2: PLC OPERATION

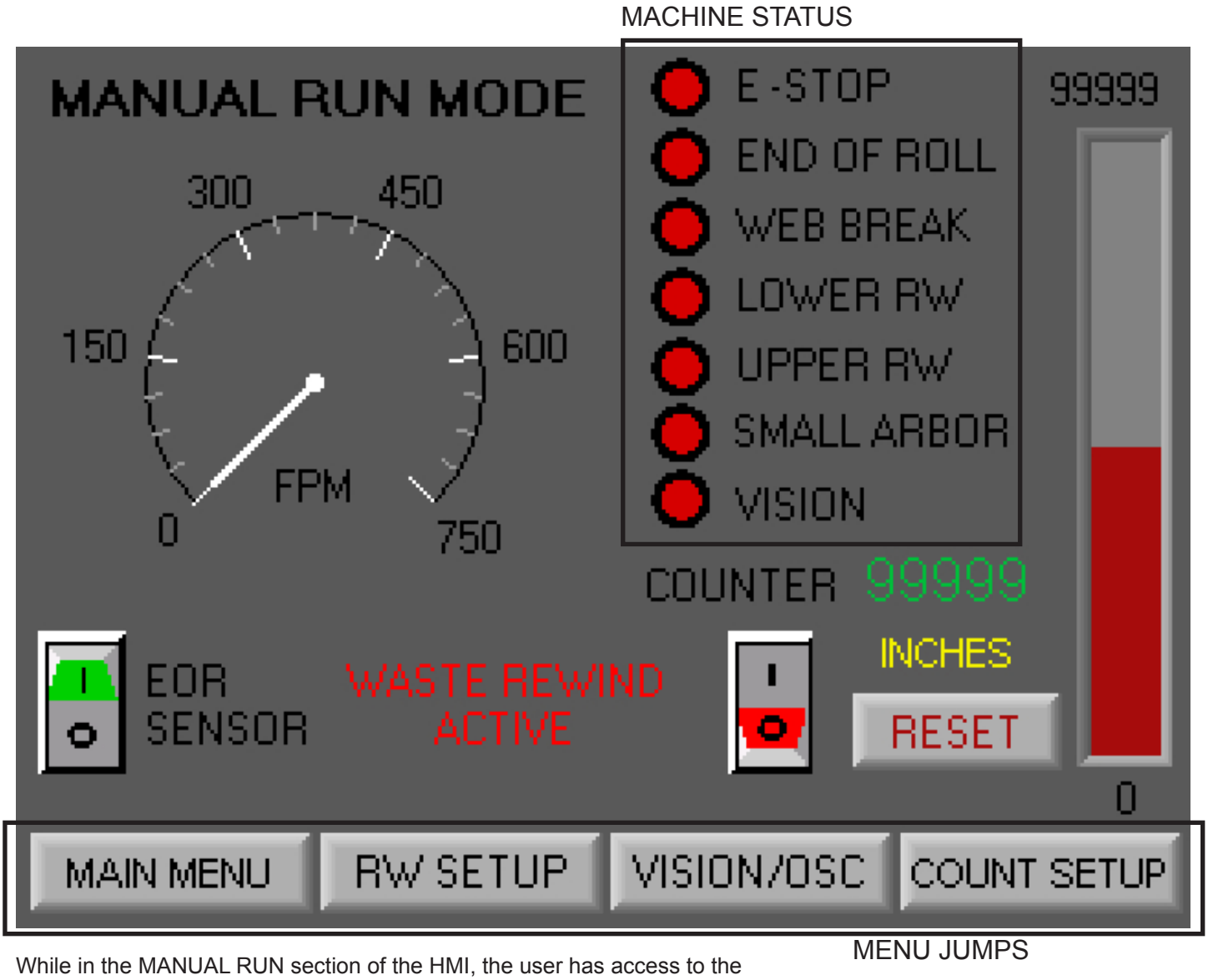
### 4-2-1: THE MAIN MENU

On power-up of the machine, the PLC will boot. This is analogous to a home PC booting. It can be expected to take between 30 and 60 seconds.

When the PLC has finished booting, the MAIN MENU will be displayed.

When the MAIN MENU is displayed, the PLC will lock-out the operator buttons and the machine will not run.

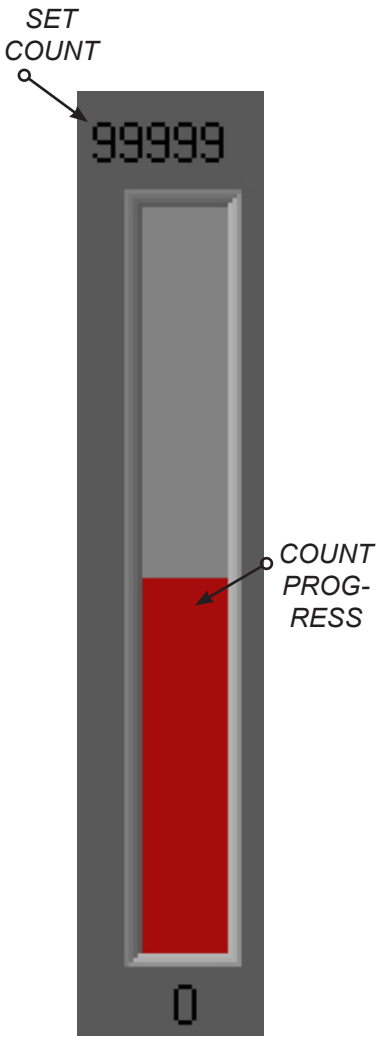
## 4-2-2: THE RUN MANUAL SECTION

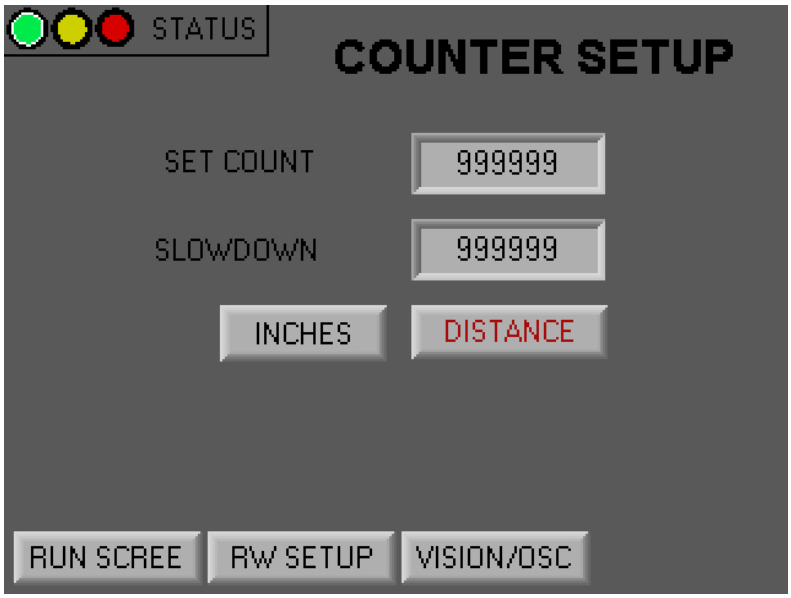



While in the MANUAL RUN section of the HMI, the user has access to the basic controls for machine operation and status. The user controls will operate the machine to parameters set here while in the MANUAL RUN section of the HMI.

Basic machine status is shown by the line of small LED icons in the center right of the screen. Green is generally used to indicate ON or ACTIVE and red is used to illustrate OFF or DISABLED.

## COUNTER SETUP



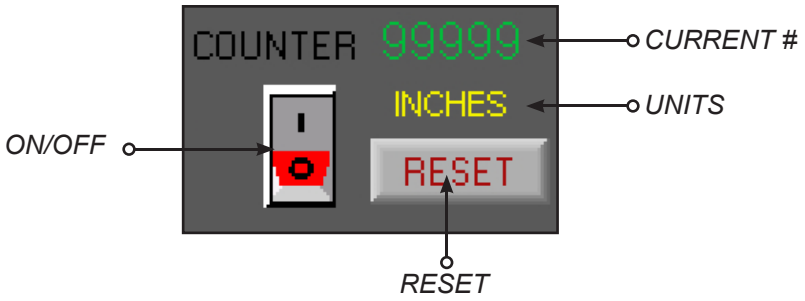




The current state of the counter is shown by the percentage scale bar on the right hand side of the screen. The fill is based on % of the set count. The precise count is shown in green on the lower left of the counter bar. Pressing the RESET button clears the count and toggling the COUNTER I/O switch will prevent the counter from incrementing.

The counter preset points can be modified by accessing the COUNTER SETUP screen from the RUN MANUAL screen. The buttons for this and other screen-jumps are displayed as a banner on the bottom of the RUN MANUAL screen. These jumps will also access the re-wind functions and return the user to the MAIN MENU.

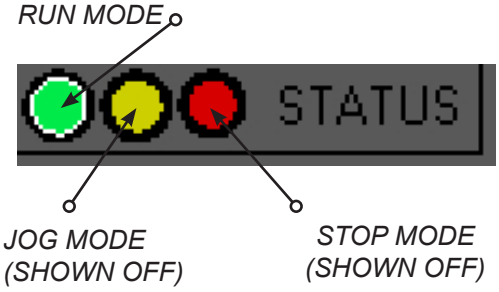
While in the setup for the counter, the user programs the SET COUNT and the SLOWDOWN point. While the counter is on, the machine will run at set speed until the SLOWDOWN count is reached. The machine will then travel at JOG speed until the SET COUNT is reached. Both points are programmed by touching the number. Once pressed, a dialogue will open to allow the user to edit the number.

***If the slowdown count is set higher than the SET COUNT, the machine will not enter slowdown when running. If the SET COUNT is set below the SLOWDOWN count, the machine will run the whole job slow.***



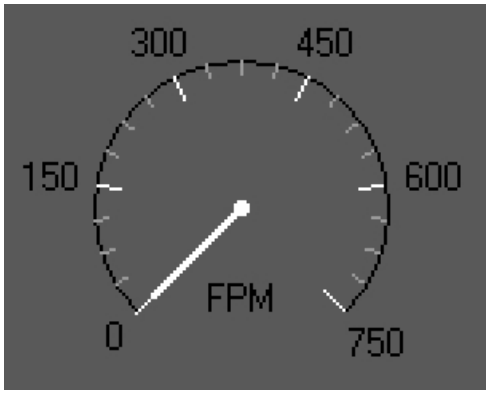
The button below the number entry boxes is used to toggle between DISTANCE and LABEL count. Toggling the button changes its display from “DISTANCE” to “LABELS” and vice versa. It also toggles a relay within the main cabinet that switches between sensor inputs to the counter on the PLC. The state of this selection is listed on the RUN screen next to the counter. While in DISTANCE mode, the option is given to count in Inches, Feet, Yards and Meters.

Pressing the RUN MENU button on the bottom of the screen returns to the RUN MENU. Alternatively, the RW SETUP and OSCILLATOR setup may be accessed from the COUNTER SCREEN.

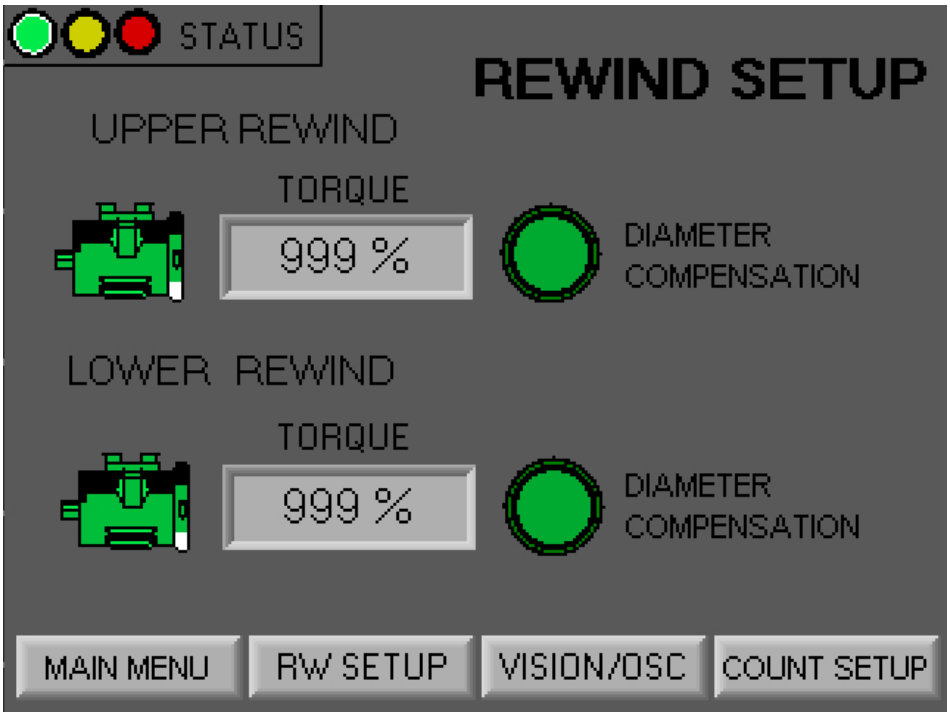



In the upper-right corner of the COUNT AND REWIND SETUPS is a STATUS indicator. This is to inform the user of the machine’s state while out of the RUN MENU. Green indicates the machine is in RUN MODE, yellow JOG and red indicates that the machine is STOPPED.

Also on the RUN MANUAL screen is a rate meter in the upper right corner. This displays approximate FPM as counted by a wheel in contact with an idler roller on the post-process side of the NIP assembly. If the gauge is shaky or inaccurate, check to make sure that the web is not slipping on the idler roller.



## REWIND SETUP




Setup for the REWIND arbors is also accessed from the RUN MANUAL screen. Using the menu jumps, the RW setup screen is loaded. In the REWIND SETUP screen, the torque is set for the UPPER and LOWER rewind, the UPPER and LOWER rewind are ENABLE/DISABLED and TORQUE COMPENSATION may be engaged.

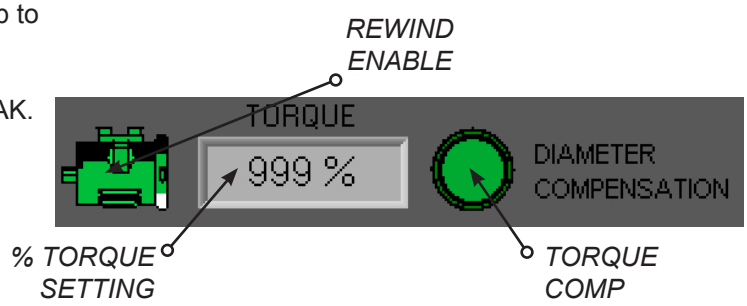
Pressing the motor icon for the selected arbor will ENABLE/DISABLE the arbor. A green icon indicates the arbor in ENABLED. A red icon indicates the arbor is DISABLED.

The number box may be pressed to open a dialogue to edit the set torque. Set torque is 0-100% scale.

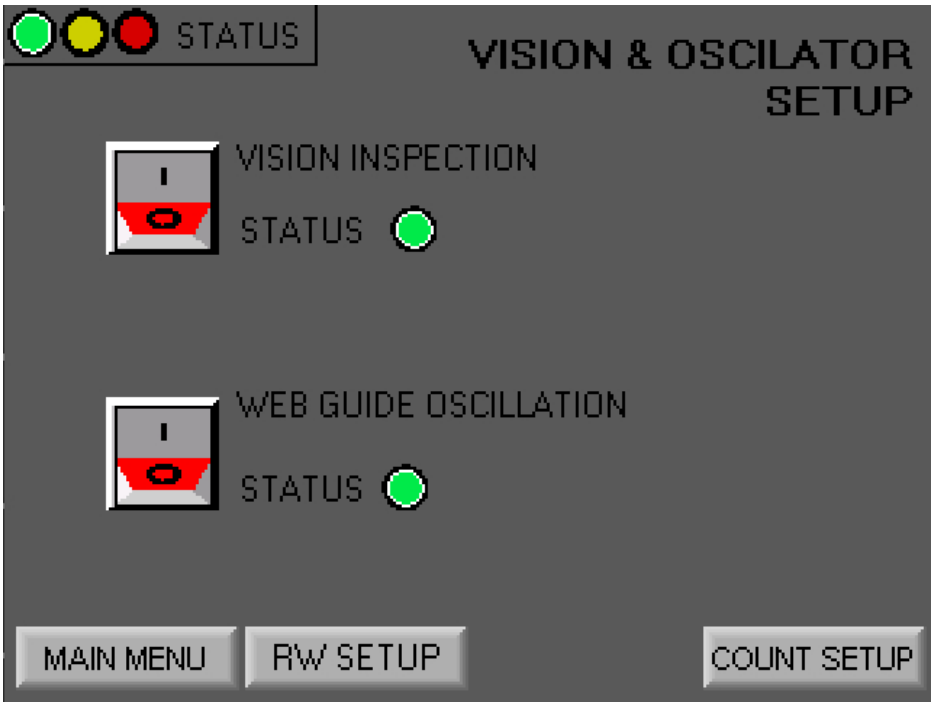
The large LED icon ENABLES/DISABLES the torque compensation.

TORQUE COMPENSATION adds 30% torque linearly up to 30” in roll diameter, if available.

Roll diameter calculations are also related to WEB BREAK. See the section on WEB BREAK for more information.



## ACCESSORY SETUP



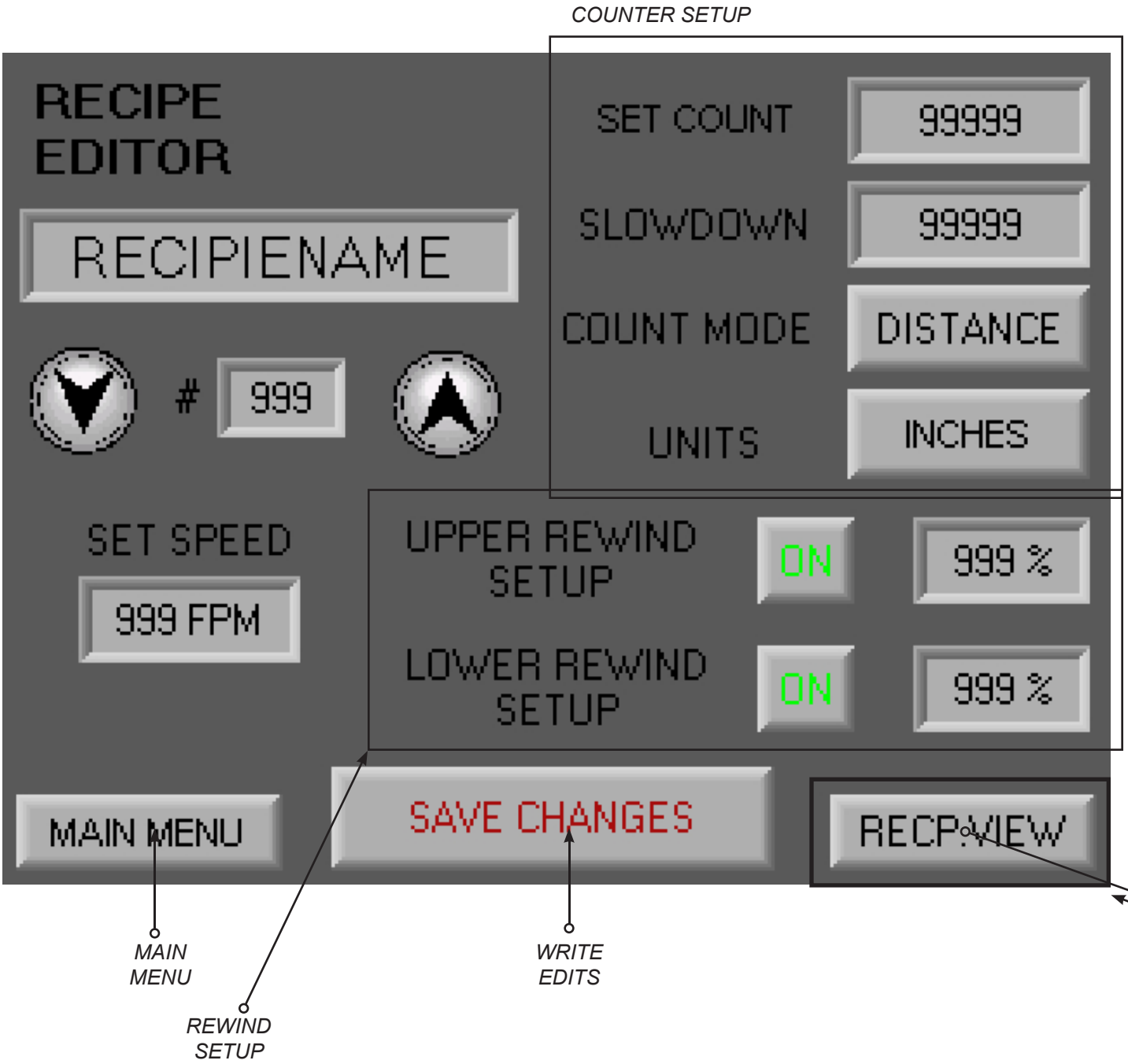

The SR series machine may be equipped with a vision inspection system or a web oscillation system produced by one of AZTECH's production affiliates. This section will detail the HMI operation of these features. If your machine is not equipped with either of these features, their associated controls will not be present on the screen.

The vision inspection system uses an optical camera to compare labels as they travel on the web to a "golden" sample. If the machine detects a label that is flawed compared to the golden, the system sends a signal to the machine to JOG as long as the signal is HIGH. By adjusting the length of this slowdown signal on the vision inspection system, the machine can be made to stop the flawed label on the inspection table. Please refer to the manual for the vision inspection system for more information on the vision system and please refer to AZTECH DWG 20298 for more details on the interface between the machine and vision system.

The machine may also be equipped with a web oscillation feature that is driven by the web guide. This oscillation can be used for the prevention of gauge bands when working with materials that have non-uniform thickness.

When the oscillation is active, the SR will send a signal to the web guide to oscillate the web as long as the machine is in RUN or JOG mode, i.e. the web is moving. The degree of this oscillation is controlled by setting parameters on the web guide. Please refer to AccuWeb's manual for more details.

The PLC functions pertaining to the WEB OSCILLATION system may be shut off on the HMI in the RUN screens.


COUNTER SETUP
RECIPE EDITOR
RECIPIENAME
#
999
SET COUNT
99999
SLOWDOWN
99999
COUNT MODE
DISTANCE
UNITS
INCHES
SET SPEED
999 FPM
UPPER REWIND SETUP
ON
999 %
LOWER REWIND SETUP
ON
999 %
MAIN MENU
SAVE CHANGES
RECP:VIEW
MAIN MENU
REWIND SETUP
WRITE EDITS

## 4-2-4: RECIPE EDITOR

The recipe editor is a table program for entering and storing job data. The job parameters such as run speed and re-wind tension are stored in the editor and then recalled in the RUN RECIPE routine and used to run jobs.

While in the RECIPE EDITOR, the operator buttons on the machine will be locked out and will not allow the machine to run. This is a safety feature.

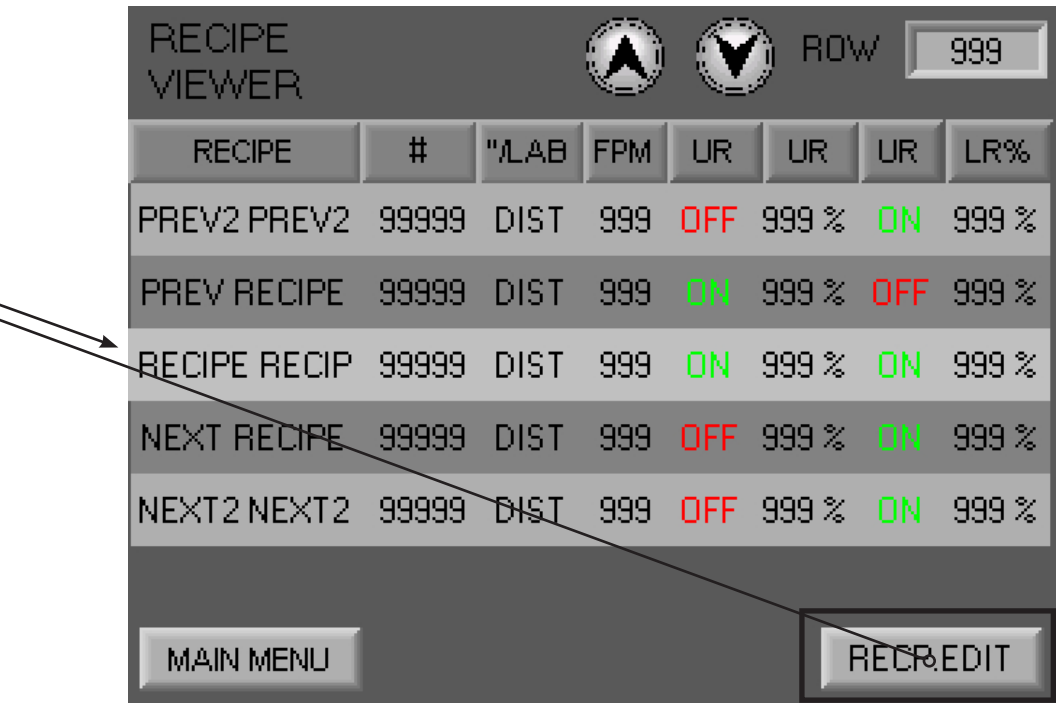
The RECIPE EDITOR is used to change the stored parameters of the jobs. It can be accessed from either the MAIN MENU or the RUN RECIPE section.

Edits are made by pressing the attributes. Once a change has been made, the SAVE CHANGES button must be pressed or the new information will not be stored.

The REWIND TENSIONS and FPM have set ranges. Tensions may be entered 0-100 and FPM may be entered 0-750. If the HMI will not take a value, it is possible that the value is out of range. Try re-entering within this range.

The UP and DOWN arrows are used to navigate the table one row at a time. The HOME ROW button will load the begging of the table.

Once edits are saved, the recipes may be used to run jobs in the RUN RECIPES section of the HMI.




A table view is provided for ease of recipe navigation. Pressing the RECP. EDIT button will allow the user to edit the middle row.

## 4-2-5: RUN RECIPES

The RUN RECIPES section of the HMI is used to execute job programs saved in the RECIPE EDITOR section.

From the MAIN MENU, the RUN RECIPES screen is loaded when the RUN RECIPES button is pressed.

The current loaded recipe is shown in the RECIPE name box. Recipes may be loaded using the up and down arrows under the RECIPE name box.

*NOTE: If edits are made to the current loaded recipe, the job must be reloaded using the arrow buttons to update.*

The recipe details will be shown in green in the center of the screen. Take note of which rewind arbors are engaged. Running web to the wrong arbor will have negative results.

Below the recipe details is a counter bar to indicate % of the run completed. The operation of this bar is similar to the completion bar in section 4-2-3. To the right of the bar, the current process count is displayed. The toggle switch to the right may be used to stop the counter at its current count and run material without incrementing the counter, for example, to remove bad material.

At the completion of a run, the progress bar will show 100% completion and the machine will stop. At this point, the START button will not re-start the machine. This is caused be the machine registering a complete run. The job may be cleared by pressing the RESET JOB button. At this point, the progress bar will be empty and the machine is ready for a second run.

The machine will not start a job if the web is still moving. The machine will indicate if it is ready to start a job by displaying a green icon on the lower right corner of the HMI.

RECIPE SELECT
RUN RECIPES
EDIT RECIPE
CHECK SMALL ARBOR LOCK
RECIPIENAME
WASTE REWIND ACTIVE
WEB BREAK
#
999
SET SPEED
999 FPM
SET COUNT
99999
UPPER RW
999 %
SLOWDOWN
99999
LOWER RW
999 %
COUNT UNITS
LABELS
-99999
READY TO RUN
MAIN MENU
RESET
MAIN MENU
RECIPE PARAMETERS
READY TO RUN LED
RESET JOB

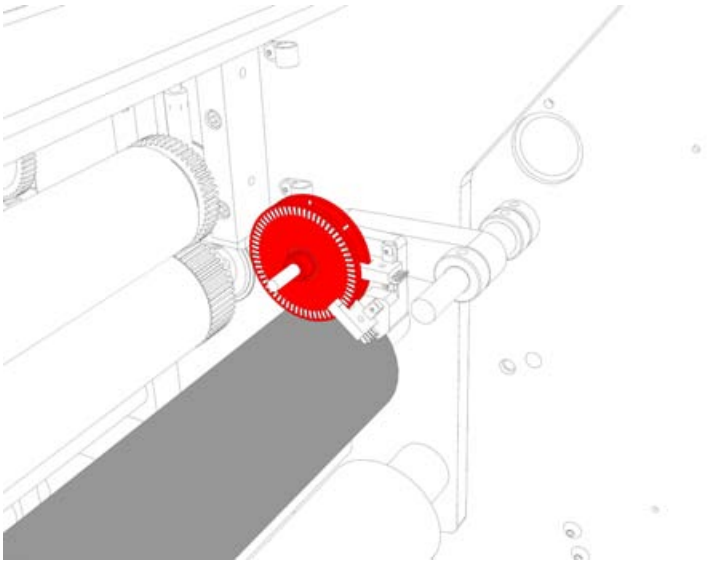
## 4-2-6: WEB BREAK

The SR Series is equipped with a safety routine to stop the machine in the event of web break. (Loss of material moving through the machine.)

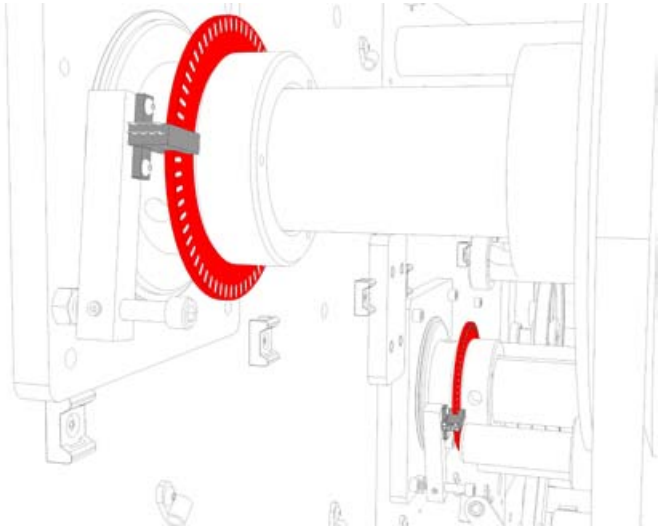
The WEB BREAK routine relies on computing the diameter of the rewind roll by comparing the RPMs of the rewind arbor to the linear measurement of web moving through the nip section.

The linear measurement of web is taken from a counter wheel in contact with an idler roller located in the post-process section of the nip assembly. This is a 64 count per rev wheel, and with a diameter of 2.547", it registered 1/8" travel for every encoder pulse.

The RPM measurement of the arbor is taken by a similar encoder mounted inside the machine. This encoder



*NIP ENCODER*



*REWIND ENCODER*

registers 64 pulses for every revolution of the rewind arbor. Consequently, the amount of material measured per-pulse increases with roll diameter.

From these two frequencies, we have:

(NIP Hz / RW Hz) = ROLL DIAMETER / 2.547

Once the machine is moving, a register containing the last 5 values of calculated roll diameter is maintained. If the average of this register is less than 2" (minimum arbor diameter) a web break is triggered. If the diameter is seen to decrease during the run, a web break is triggered. (The rewind roll should never get smaller...)

Due to the nature of these calculations, various sources of error may result in false web-breaks.

The most common source of error is slipping on the NIP encoder. When the material slips on the NIP encoder, the diameter is seen to be artificially small. This will cause repeated web-breaks and a machine that will seem to not want to run a job.

If this happens, check the contact of the counter wheel to the idle roll to make sure the surface is clean. Secondly, check the tension to make sure the material has adequate "grab" on the idle roller.

### 4-2-7: PLC RESOURCES

The PLC is manufactured by Unitronics.

866-666-6033
usa.sales@unitronics.com
*www.unitronics.com*

The PLC is programmed using:

**VisiLogic 9.7.44**

VisiLogic is available for free download at www.unitronics.com. Consult the Unitroncis website for technical details on the PLC.

Motor drives are made by K&B Electronics

Spares, technical support and service are provided by:

**AZTECH Converting Systems Inc**
212 W Lodge St.
Phoenix, AZ 85283
**techservice@aztechconverting.com**
**(800) 829 - 8351**

### 4-5: Rewinding Large Diameter Rolls

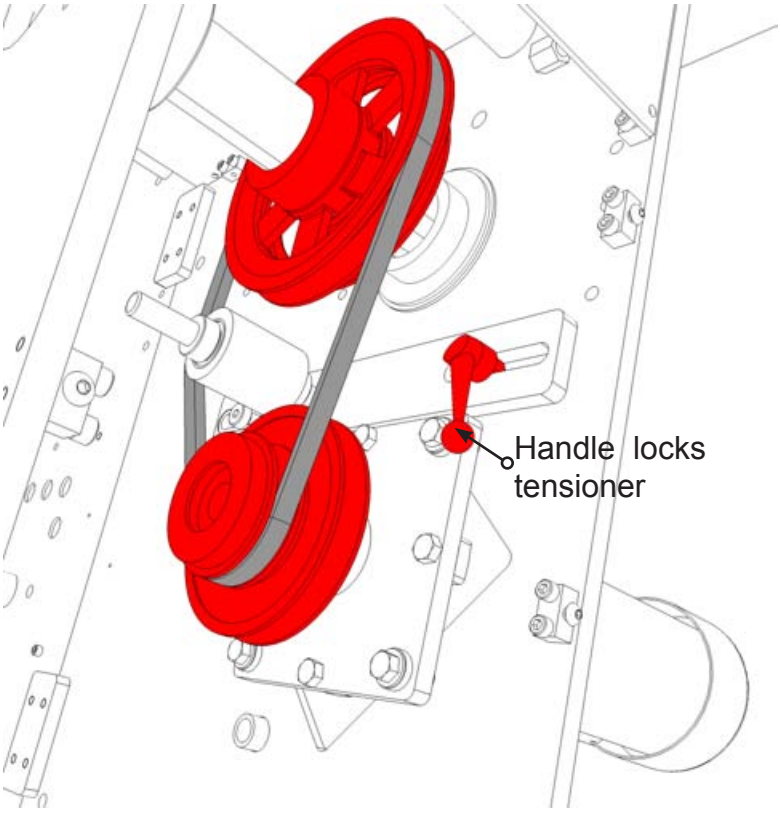
When rewinding large diameter rolls with the SR-Series, it is critical to steadily increase tension as the roll diameter increases and minimize trapped air in the finished rolls. It is recommended that the operator set the rewind tension at a low setting at the beginning of the roll, and gradually increase the rewind tension by either manuallly entering larger numbers into the re-wind tension field on the PLC as the diameter increases or by selecting the diameter compensation option.

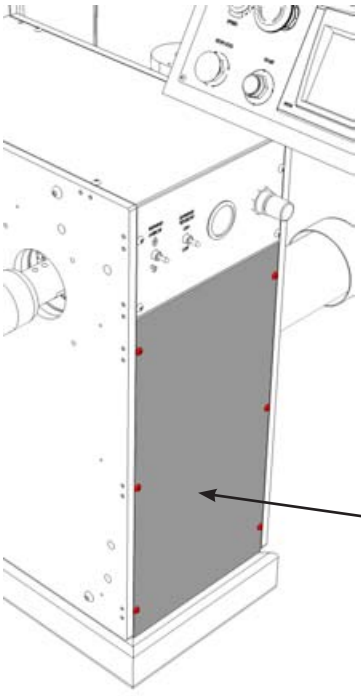
To achieve consistent large-diameter rolls, it is critical to use the top-rider assembly to avoid trapping air. If your SR-Series machines not equipped with a top-rider, they are easily installable and may be purchased by contacting AZTECH Machinery.

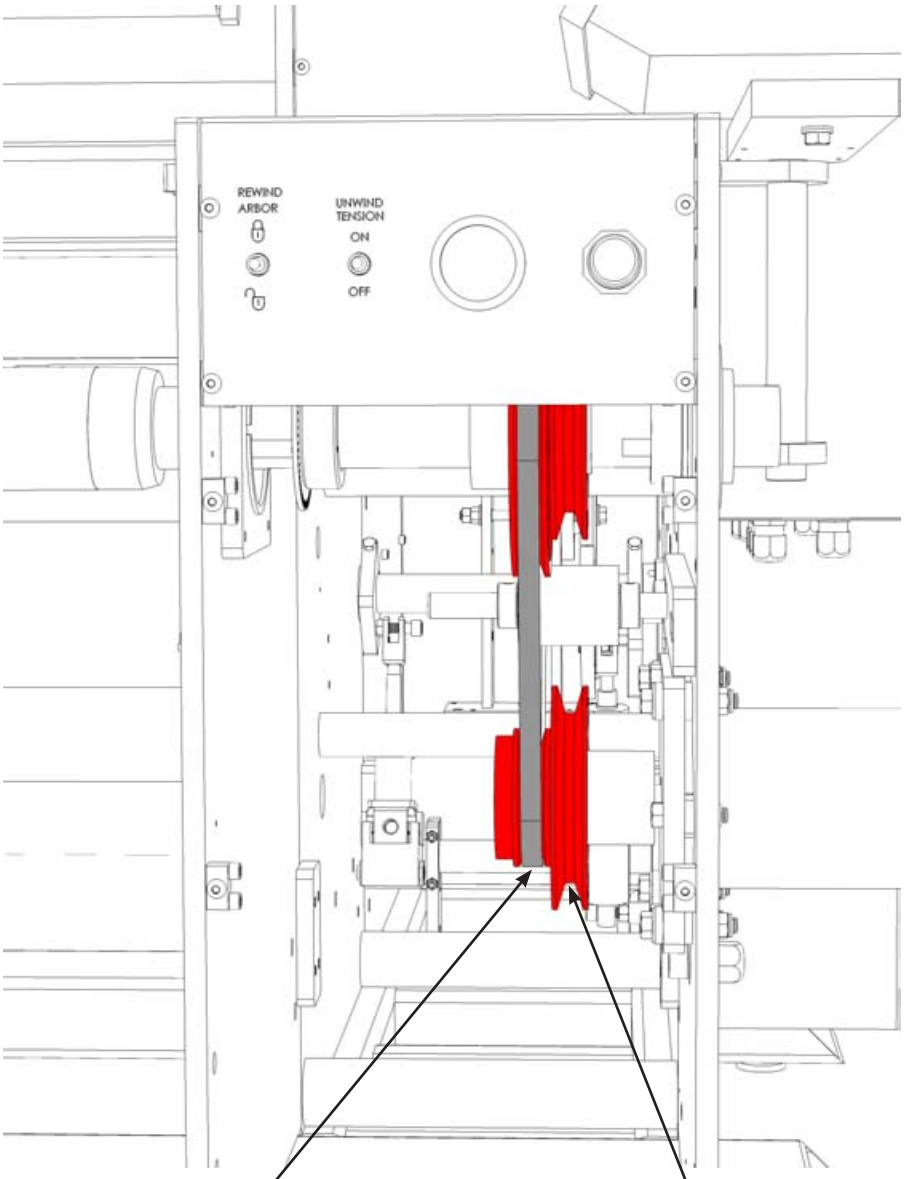
### 4-6 Increasing Web Speed

The  comes with default settings (see figure 4-D) that allow for peak performance for slitting and rewinding various substrates and roll sizes. If you wish to increase the web speed, you may at your discretion, switch over the rewind belt(s) which will change the ratio of web speed as follows:

1. Open or remove rewind panel.
2. Loosen handle by turning counterclock-wise and pulling belt-tightener-arm outward.
3. With belt loose, change over to opposite pulleys.
4. Push belt-tightener arm inward and tighten handle clock-wise.
5. Close or replace rewind panel.






**CAUTION: BY SWITCHING BELTS TO INCREASE WEB SPEED, THE SR WILL TAKE LONGER TO STOP, ESPECIALLY WHEN RUNNING AT HIGH SPEED WITH A LARGE OR HEAVY UNWIND ROLL. IF DIFFICULTIES OCCUR, SWITCH BELTS BACK TO THE DEFAULT SETTING.**

## Section 5: Maintenance

### 5-1: Maintenance

Your SR-Series Slitter Rewinder is rigidly constructed to provide your company years of productivity, while being relatively maintenance free. However, to aid in assuring maximum performance and longevity, the occasional following maintenance is recommended:

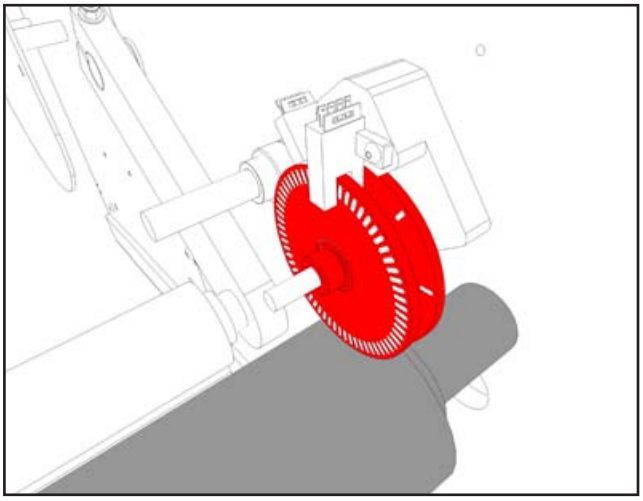
• Apply a small amount of clear silicone grease to all gears.

• Inspect belts for tightness and wear and tighten or replace as necessary.

• Clean rubber nip roll using a rag and denatured alcohol. DO NOT USE A RAZOR BLADE OR ABRASIVE PAD AS THEY WILL CAUSE IRREPARABLE DAMAGE TO THE ROLL SURFACE.

• Replace any of the slitting blades if they are noticeably chipped or damaged, or if you notice excess slitting dust or if the blades are not cutting cleanly.

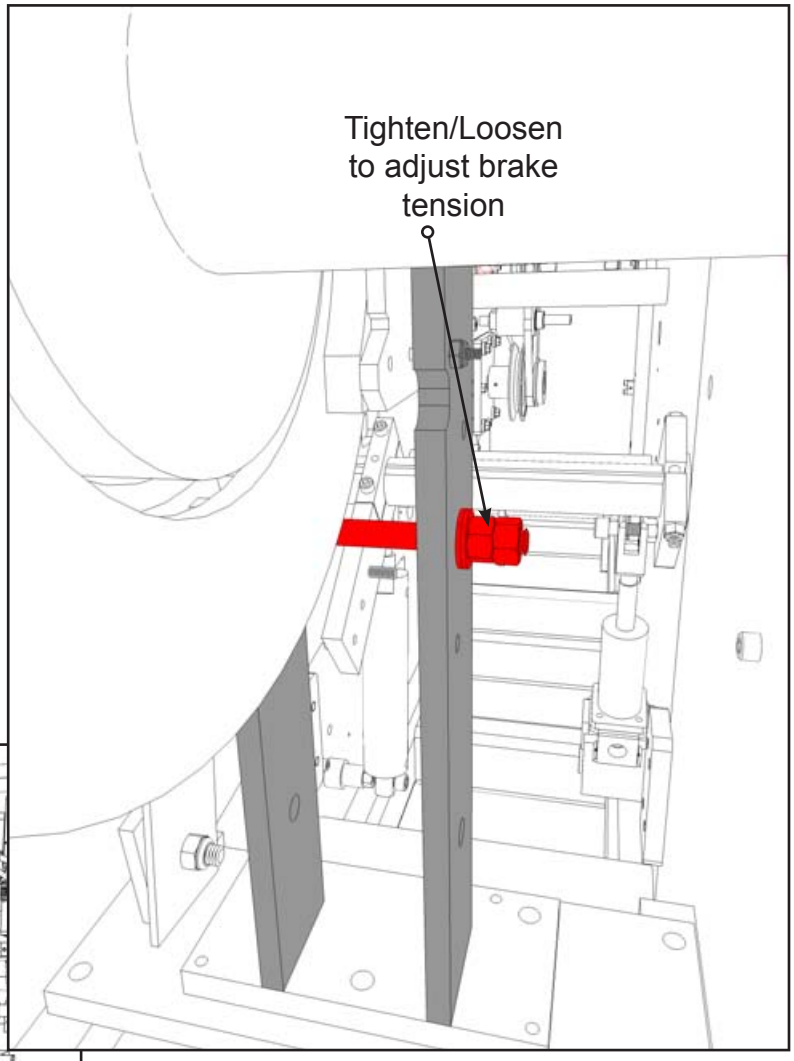
• Clean counter wheel (see figure 5-A) by blowing with air nozzle assuring all holes are free of dust or debris.

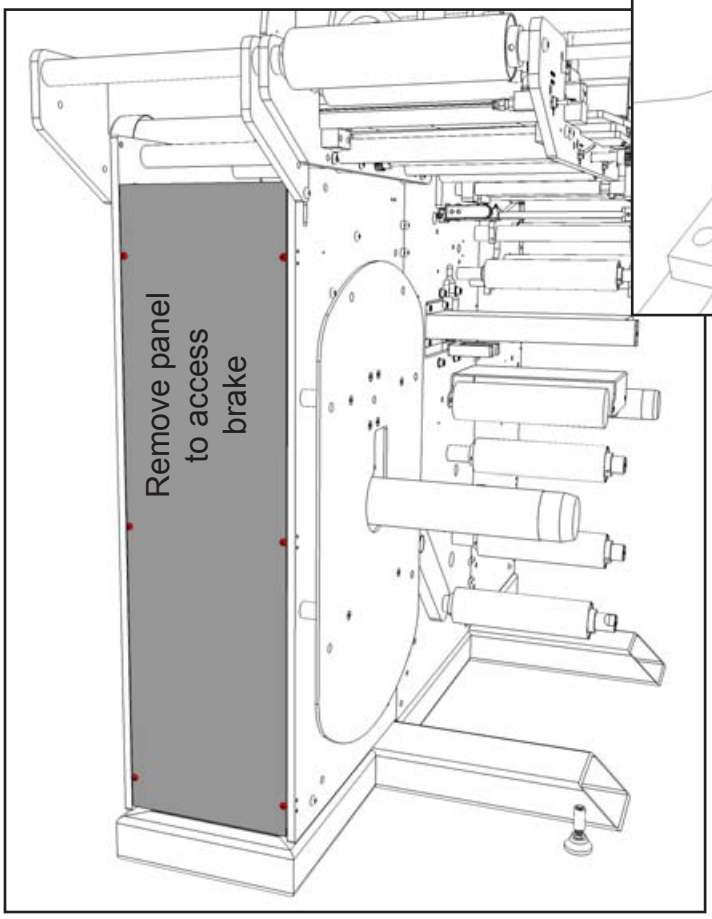


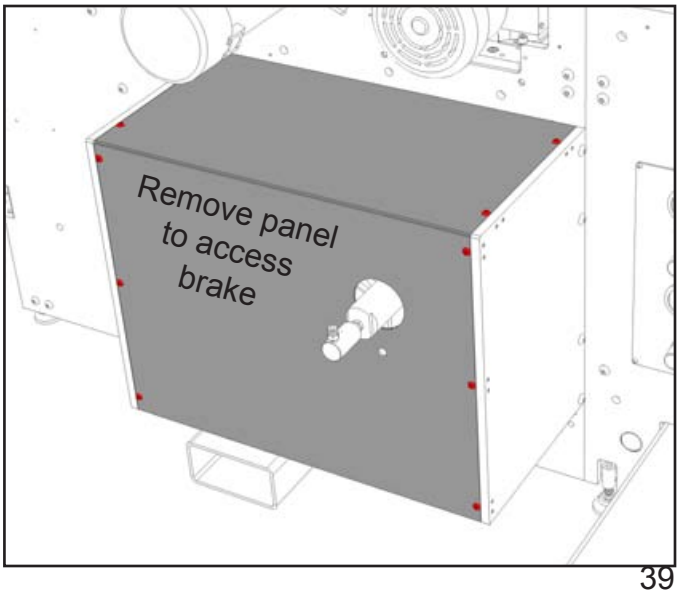
## 5-2: Adjusting the Unwind Brake

The unwind brake on the  may require occasional adjustment. To adjust the brake, follow these simple instructions:

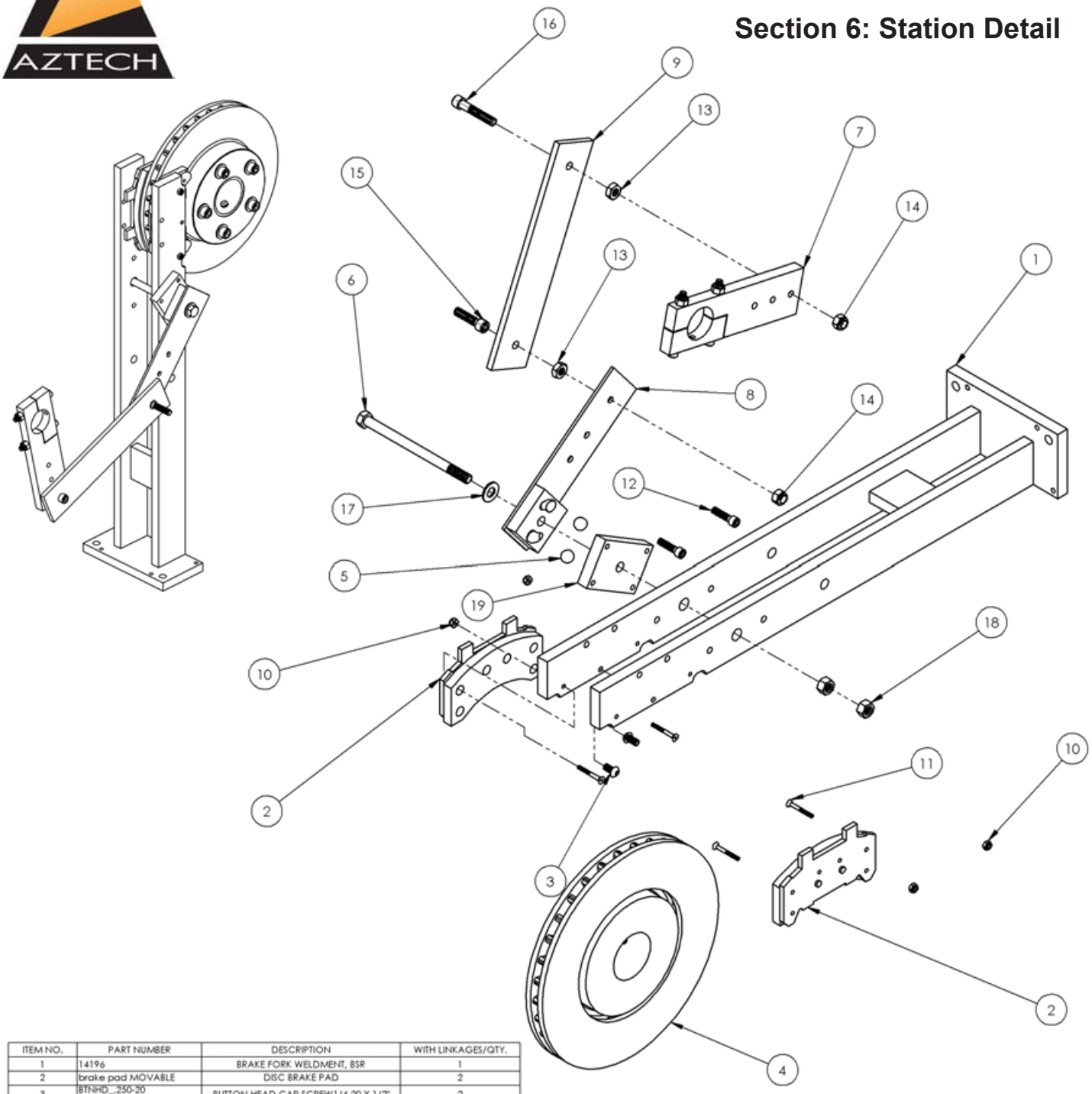
1. Remove unwind station cover.
2. Raise and hold dancer arm into a level position and while holding in level position, spin the unwind spindle with other hand. The unwind spindle should spin while feeling some resistance. If the spindle is free moving or unable to move, adjust brake by loosening nut and lock nut on backside of the unwind station, adjust accordingly, tighten nut and re-check. Repeat this procedure until properly adjusted.
3. Replace unwind station cover.



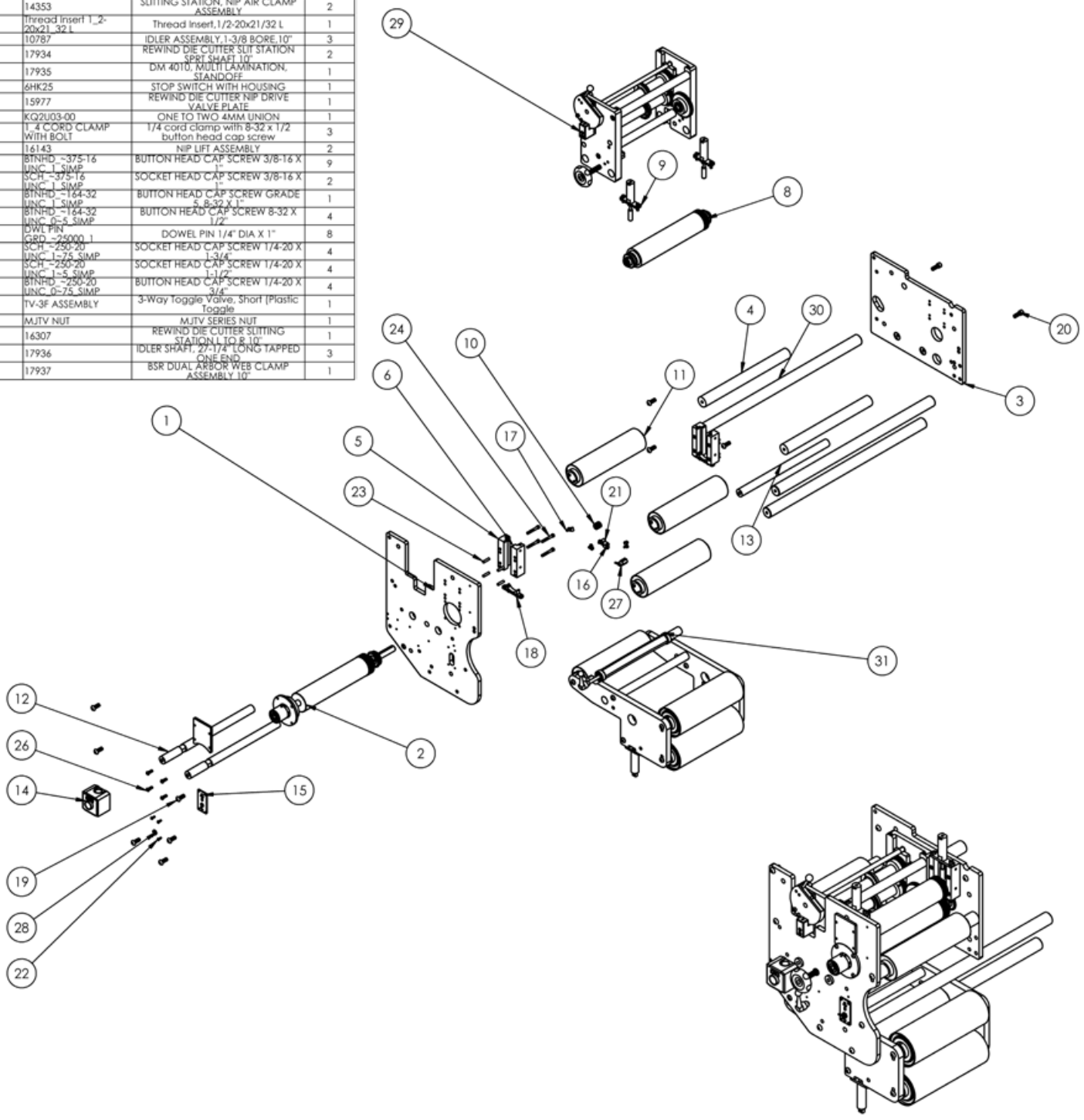



## Section 6: Station Detail



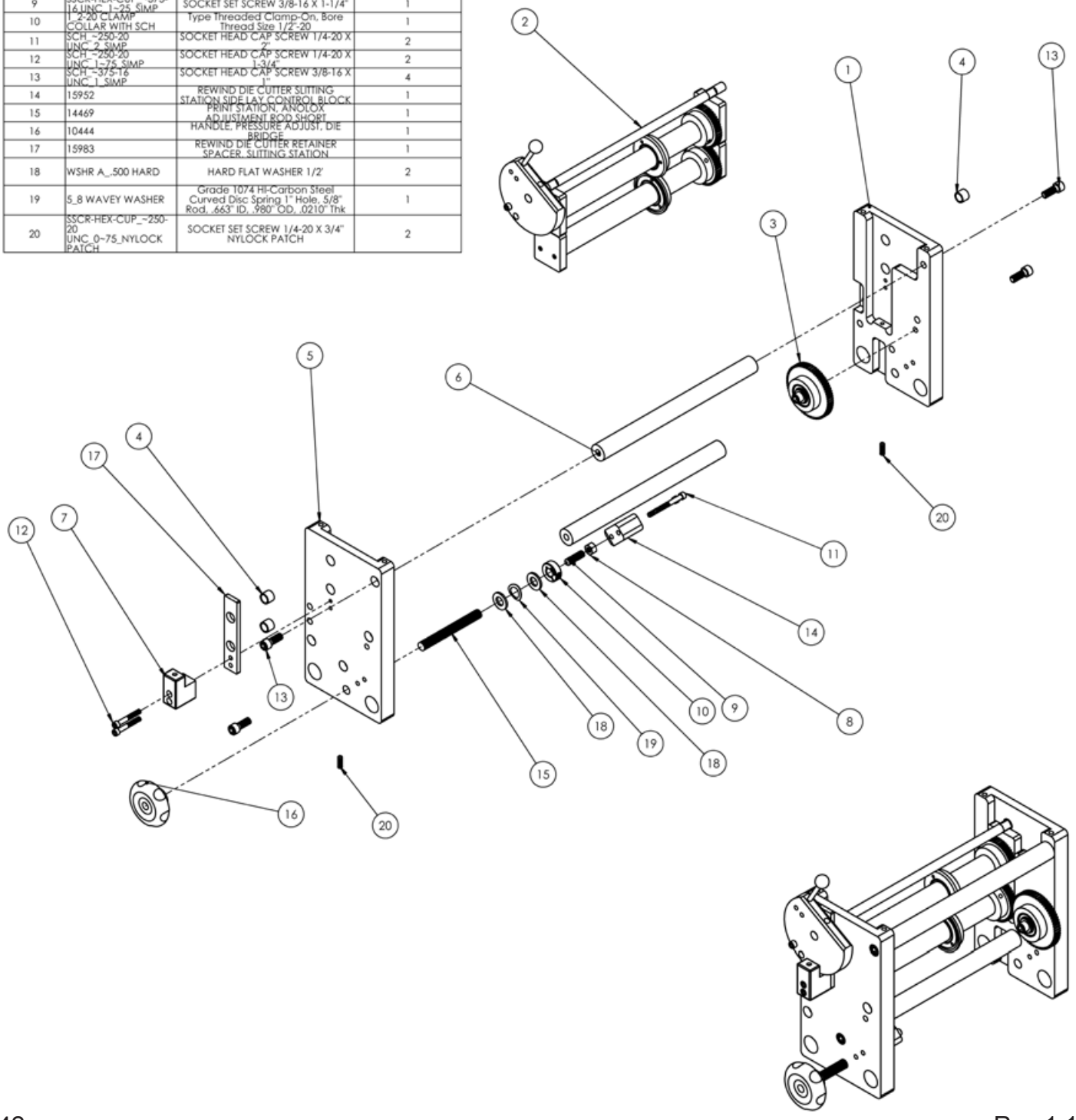

| ITEM NO. | PART NUMBER | DESCRIPTION | WITH LINKAGES/QTY. |
|---|---|---|---|
| 1 | 14196 | BRAKE FORK WELDMENT, BSR | 1 |
| 2 | brake pad MOVABLE | DISC BRAKE PAD | 2 |
| 3 | BTNHD_.250-20 UNC_0.5_SIMP | BUTTON HEAD CAP SCREW1/4-20 X 1/2" | 2 |
| 4 | 11418 | BRAKE ROTOR ASSEMBLY | 1 |
| 5 | 1_2 BALL | MCMASTER-CARR# 96455K56 | 2 |
| 6 | HEX BOLT_~375-16 UNC_5~5_SIMP | HEX BOLT GRADE 5, 3/8-16 X 5.5" | 1 |
| 7 | 11813 | CAM BRAKE MASTER ARM PIVOT | 1 |
| 8 | 11823 | BRAKE PIVOT ARM ASSEMBLY,BSR,SR,DM | 1 |
| 9 | 11822 | BRAKE TRANSFER LINK, NEW REWINDER | 1 |
| 10 | HEX NUT 6-32 LOCK | HEX NUT 6-32 NYLOCK | 4 |
| 11 | FLH-SCH-82_~138-32 UNC_1~25_SIMP | FLAT HEAD CAP SCREW 6-32 X 1-1/4" | 4 |
| 12 | SCH_~250-20 UNC_1_SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 1" | 2 |
| 13 | HEX MS NUT_0~3125-18 UNC_SIMP | HEX NUT 5/16-18 | 2 |
| 14 | HEX NUT_3125-18 UNC_LOCK | NYLOCK NUT 5/16-18 | 2 |
| 15 | SCH_~3125-18 UNC_1~25_SIMP | SOCKET HEAD CAP SCREW 5/16-18 X 1-1/4" | 1 |
| 16 | SCH_~3125-18 UNC_1~75_SIMP | SOCKET HEAD CAP SCREW 5/16-18 X 1-3/4" | 1 |
| 17 | WSHR A_.375N | WASHER 3/8 N | 1 |
| 18 | HEX NUT_.375-16 UNC_0_SIMP | HEX NUT 3/8-16 | 2 |
| 19 | 11818 | BRAKE RAMP PLATE,FIXED,BSR, SR, RM | 1 |

| ITEM NO. | PART NUMBER | DESCRIPTION | Default/ QTY. |
|---|---|---|---|
| 1 | 17603 | BSR SLITTING STATION FRONT PLATE | 1 |
| 2 | 16125 | REWIND DIE CUTTER BASE ROLL ASSEMBLY 10" | 1 |
| 3 | 17788 | BSR SLITTING STATION REAR PLATE L TO B | 1 |
| 4 | 16124 | INSPECTION REWINDED WEB CLAMP IDLER SPACER BAR 10" | 2 |
| 5 | 15955 | REWIND DIE CUTTER GIBB BAR RIGHT | 2 |
| 6 | 15956 | REWIND DIE CUTTER GIBB BAR LEFT | 2 |
| 7 | 17605 | BSR SLITTING STATION FRONT GIBB PLATE | 1 |
| 8 | 16128 | REWIND DIE CUTTER NIP ROLL ASSEMBLY 10" | 1 |
| 9 | 14353 | SLITTING STATION, NIP AIR CLAMP ASSEMBLY | 2 |
| 10 | Thread Insert 1_2-20x21_32 L | Thread Insert,1/2-20x21/32 L | 1 |
| 11 | 10787 | IDLER ASSEMBLY,1-3/8 BORE,10" | 3 |
| 12 | 17934 | REWIND DIE CUTTER SLIT STATION SPRT SHAFT 10" | 2 |
| 13 | 17935 | DM 4010, MULTI LAMINATION, STANDOFF | 1 |
| 14 | 6HK25 | STOP SWITCH WITH HOUSING | 1 |
| 15 | 15977 | REWIND DIE CUTTER NIP DRIVE VALVE PLATE | 1 |
| 16 | KQ2U03-00 | ONE TO TWO 4MM UNION | 1 |
| 17 | 1_4 CORD CLAMP WITH BOLT | 1/4 cord clamp with 8-32 x 1/2 button head cap screw | 3 |
| 18 | 16143 | NIP LIFT ASSEMBLY | 2 |
| 19 | BTNHD_~375-16 UNC_1_SIMP | BUTTON HEAD CAP SCREW 3/8-16 X 1" | 9 |
| 20 | SCH_~375-16 UNC_1_SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1" | 2 |
| 21 | BTNHD_~164-32 UNC_1_SIMP | BUTTON HEAD CAP SCREW GRADE 5 8-32 X 1" | 1 |
| 22 | BTNHD_~164-32 UNC_0~5_SIMP | BUTTON HEAD CAP SCREW 8-32 X 1/2" | 4 |
| 23 | DWL PIN GRD_~25000_1 | DOWEL PIN 1/4" DIA X 1" | 8 |
| 24 | SCH_~250-20 UNC_1~75_SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4" | 4 |
| 25 | SCH_~250-20 UNC_1~5_SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 1-1/2" | 4 |
| 26 | BTNHD_~250-20 UNC_0~75_SIMP | BUTTON HEAD CAP SCREW 1/4-20 X 3/4" | 4 |
| 27 | TV-3F ASSEMBLY | 3-Way Toggle Valve, Short (Plastic Toggle | 1 |
| 28 | MJTV NUT | MJTV SERIES NUT | 1 |
| 29 | 16307 | REWIND DIE CUTTER SLITTING STATION L TO B 10" | 1 |
| 30 | 17936 | IDLER SHAFT, 27-1/4" LONG TAPPED ONE END | 3 |
| 31 | 17937 | BSR DUAL ARBOR WEB CLAMP ASSEMBLY 10" | 1 |

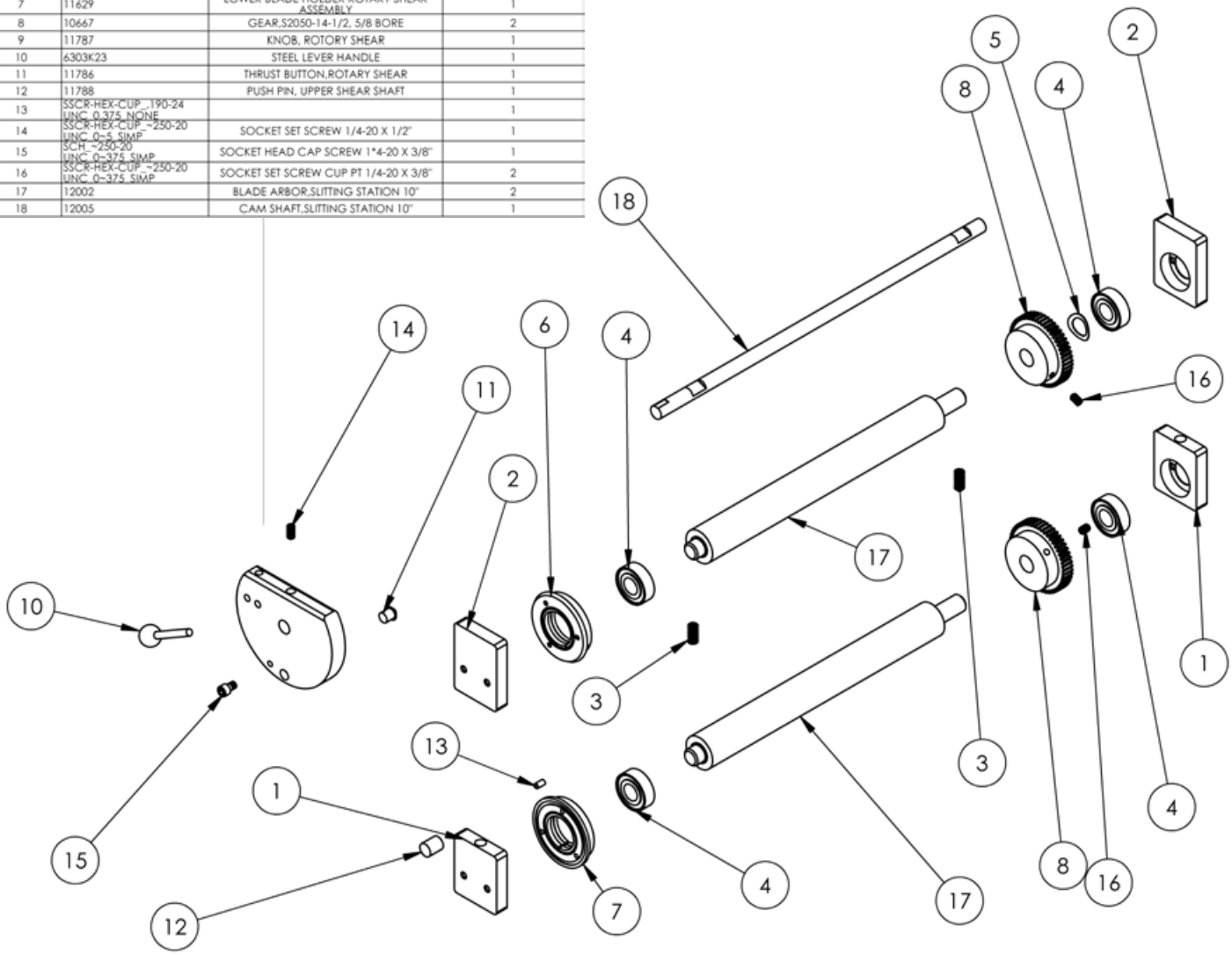


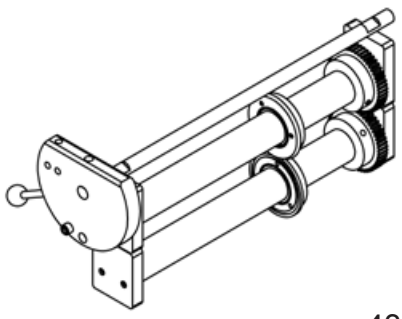
## Section 6: Station Detail

| ITEM NO. | PART NUMBER | DESCRIPTION | ROTARY SHEAR/QTY. |
|---|---|---|---|
| 1 | 15950 | REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE | 1 |
| 2 | 14373 | BSR, ROTARY SHEAR ASSEMBLY, 10" | 1 |
| 3 | 11811 | IDLER GEAR ASSEMBLY, SLITTING STATION | 1 |
| 4 | 1_2 X 5_8 X 1_2 INCH | BUSHING 6391K211 | 3 |
| 5 | 15951 | REWIND DIE CUTTER SLITTING STATION REAR GIBB PLATE | 1 |
| 6 | 16308 | SLITTING STATION ER, STANDOFF 10" | 2 |
| 7 | 11778 | RETAINER BRACKET, SLITTING STATION, BSR | 1 |
| 8 | HEX NUT_.375-16 UNC_0_SIMP | HEX NUT 3/8-16 | 1 |
| 9 | SSCR-HEX-CUP_~375-16 UNC_1~25_SIMP | SOCKET SET SCREW 3/8-16 X 1-1/4" | 1 |
| 10 | 1_2-20 CLAMP COLLAR WITH SCH | Type Threaded Clamp-On, Bore Thread Size 1/2"-20 | 1 |
| 11 | SCH_~250-20 UNC_2_SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 2" | 2 |
| 12 | SCH_~250-20 UNC_1~75_SIMP | SOCKET HEAD CAP SCREW 1/4-20 X 1-3/4" | 2 |
| 13 | SCH_~375-16 UNC_1_SIMP | SOCKET HEAD CAP SCREW 3/8-16 X 1" | 4 |
| 14 | 15952 | REWIND DIE CUTTER SLITTING STATION SIDE LAY CONTROL BLOCK | 1 |
| 15 | 14469 | PRINT STATION, ANOLOX ADJUSTMENT ROD SHORT | 1 |
| 16 | 10444 | HANDLE, PRESSURE ADJUST, DIE BRIDGE | 1 |
| 17 | 15983 | REWIND DIE CUTTER RETAINER SPACER, SLITTING STATION | 1 |
| 18 | WSHR A_.500 HARD | HARD FLAT WASHER 1/2' | 2 |
| 19 | 5_8 WAVEY WASHER | Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk | 1 |
| 20 | SSCR-HEX-CUP_~250-20 UNC_0~75_NYLOCK PATCH | SOCKET SET SCREW 1/4-20 X 3/4" NYLOCK PATCH | 2 |



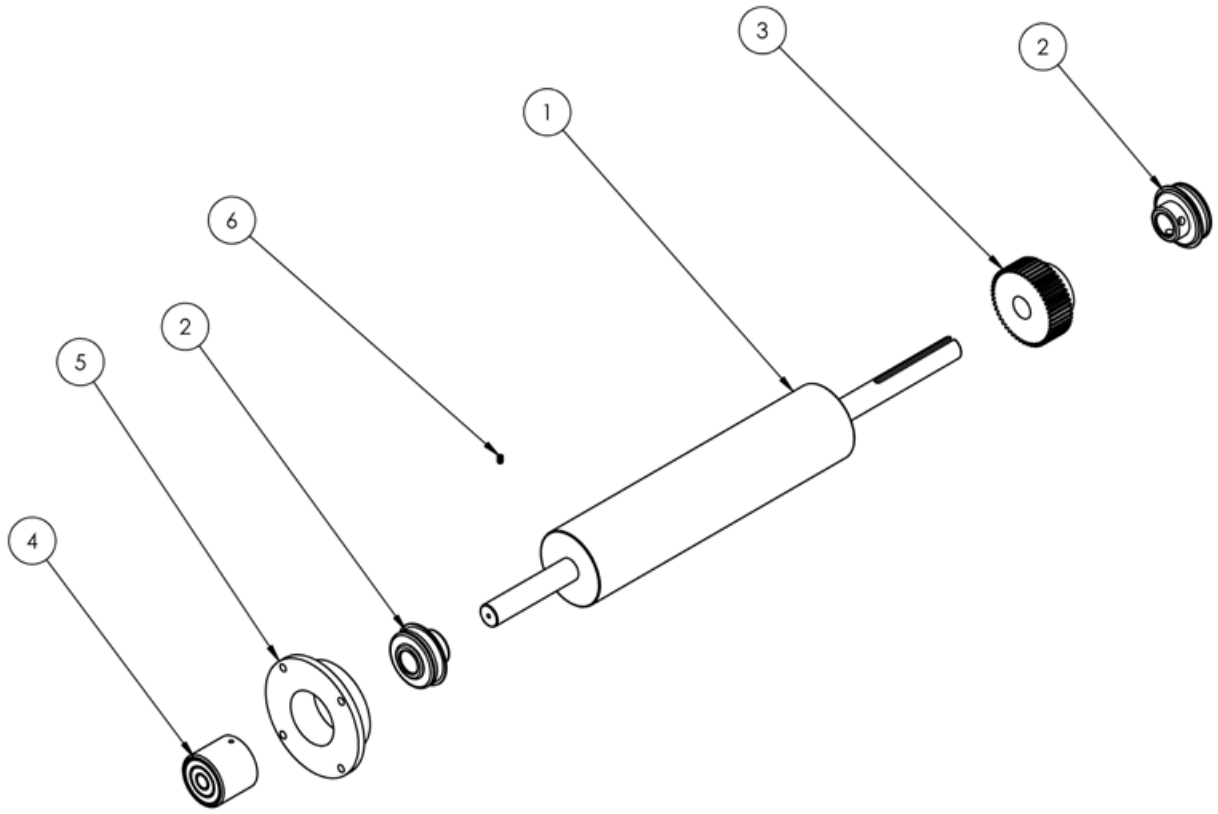
| ITEM NO. | PART NUMBER | DESCRIPTION | LEFT TO RIGHT/QTY. |
|---|---|---|---|
| 1 | 11781 | GIBB BLOCK,BLANK, LOWER, SLITTING STATION | 2 |
| 2 | 11779 | GIBB BLOCK, UPPER | 2 |
| 3 | 9657K156 | COMPRESSION SPRING .38 x .048 x 1.5 | 2 |
| 4 | 18991 | 1623 BEARING 1 3/8 OD X 5/8 ID SEALED | 4 |
| 5 | 5_8 WAVEY WASHER | Grade 1074 HI-Carbon Steel Curved Disc Spring 1" Hole, 5/8" Rod, .663" ID, .980" OD, .0210" Thk | 1 |
| 6 | 11635 | UPPER BLADE HOLDER ROTARY SHEAR ASSEMBLY | 1 |
| 7 | 11629 | LOWER BLADE HOLDER ROTARY SHEAR ASSEMBLY | 1 |
| 8 | 10667 | GEAR,S2050-14-1/2, 5/8 BORE | 2 |
| 9 | 11787 | KNOB, ROTORY SHEAR | 1 |
| 10 | 6303K23 | STEEL LEVER HANDLE | 1 |
| 11 | 11786 | THRUST BUTTON,ROTARY SHEAR | 1 |
| 12 | 11788 | PUSH PIN, UPPER SHEAR SHAFT | 1 |
| 13 | SSCR-HEX-CUP_.190-24 UNC_0.375_NONE | | 1 |
| 14 | SSCR-HEX-CUP_~250-20 UNC_0~5_SIMP | SOCKET SET SCREW 1/4-20 X 1/2" | 1 |
| 15 | SCH_~250-20 UNC_0~375_SIMP | SOCKET HEAD CAP SCREW 1*4-20 X 3/8" | 1 |
| 16 | SSCR-HEX-CUP_~250-20 UNC_0~375_SIMP | SOCKET SET SCREW CUP PT 1/4-20 X 3/8" | 2 |
| 17 | 12002 | BLADE ARBOR,SLITTING STATION 10" | 2 |
| 18 | 12005 | CAM SHAFT,SLITTING STATION 10" | 1 |



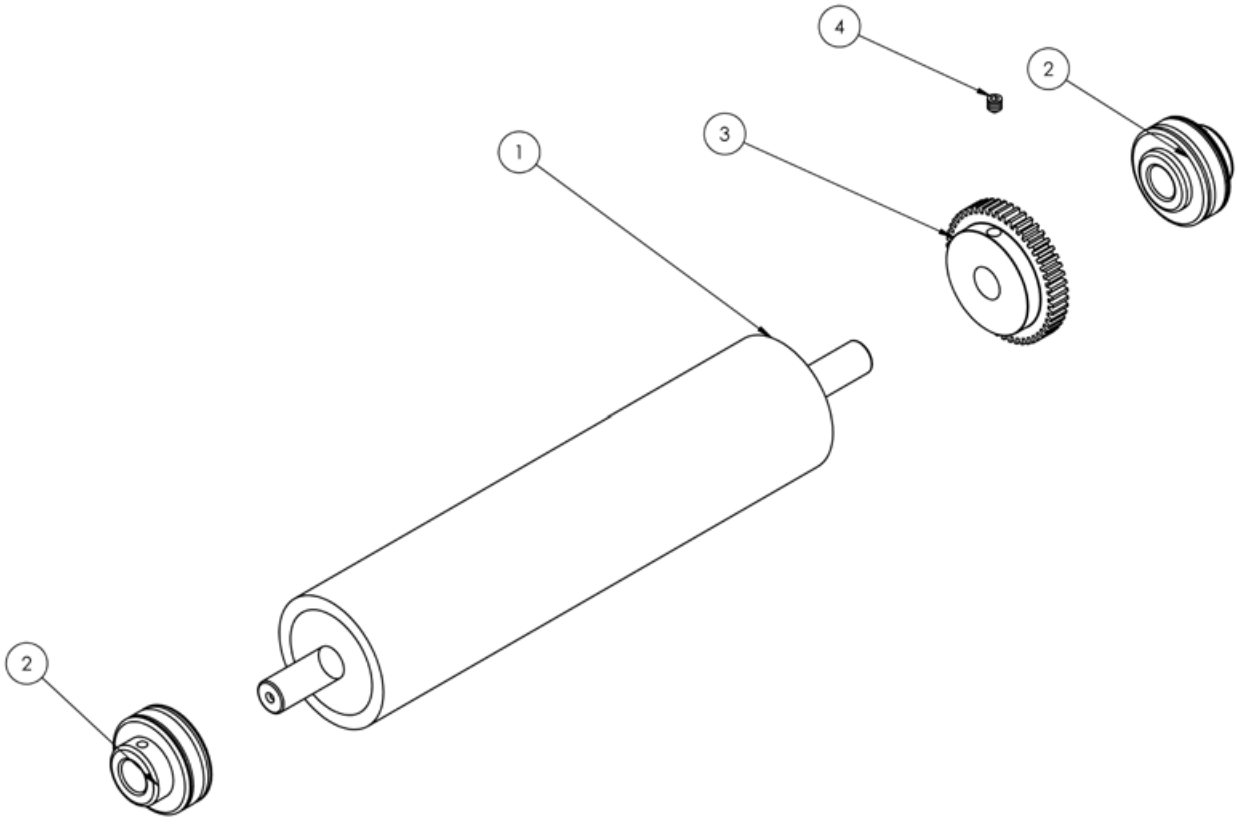



## Section 6: Station Detail

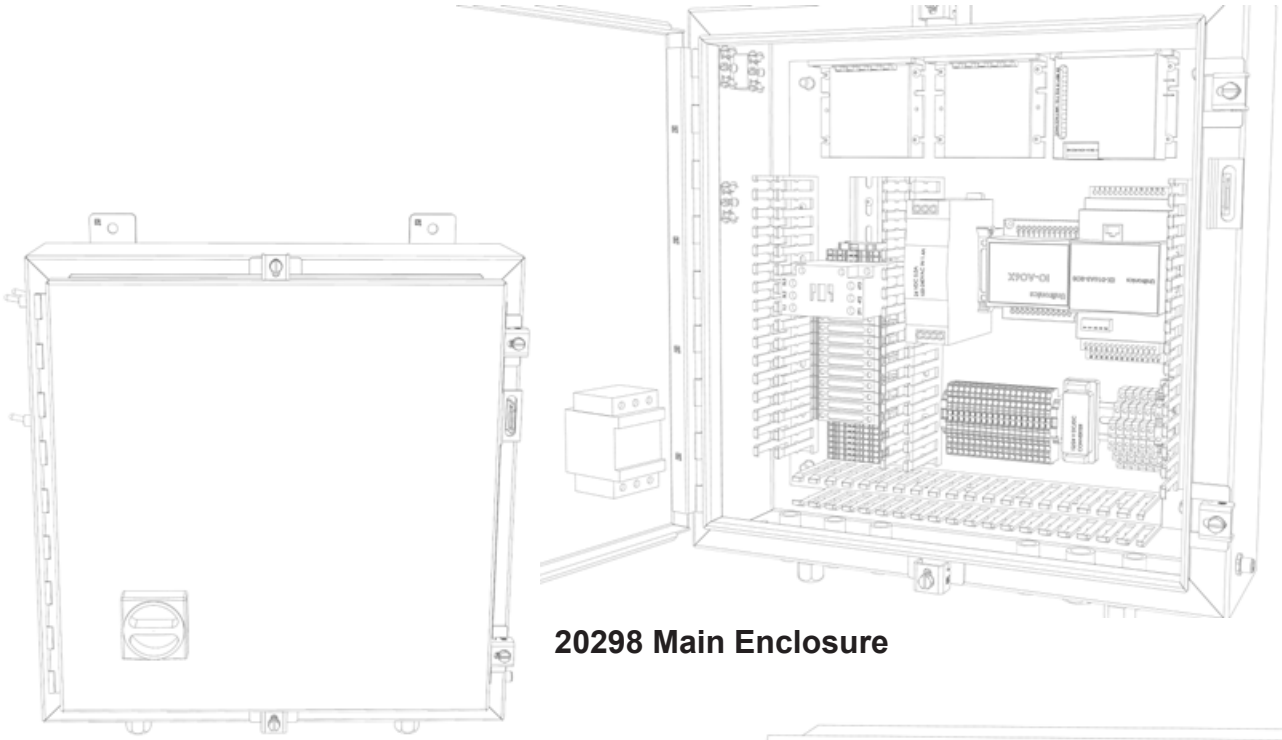
| ITEM NO. | PART NUMBER | DESCRIPTION | Default/ QTY. |
|---|---|---|---|
| 1 | 16126 | STEEL BASE ROLL, 3/4" JOURNALS SLITTING STATION 2.5465 DIA 10" | 1 |
| 2 | 0.7500er-12 | ER-12 .750 ID 1.8504 OD | 2 |
| 3 | 15988 | GEAR ,S2050-14-1/2, 3/4 BORE | 1 |
| 4 | 15861 | NIP ROLL KNOB 3/4 BORE | 1 |
| 5 | 15961 | REWIND DIE CUTTER PACE ROLL FRONT BEARING CAP | 1 |
| 6 | SSCR-HEX-CUP_~164-32 UNC_0~25_SIMP | SCH 8-32 X 1/4" | 1 |



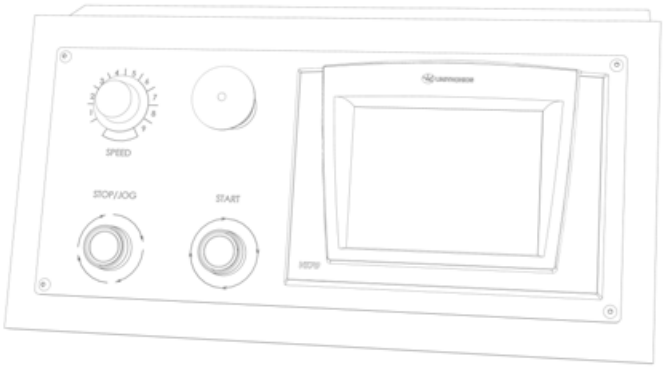
| ITEM NO. | PART NUMBER | DESCRIPTION | INSPECTION REWIND/QTY. |
|---|---|---|---|
| 1 | 16118 | COATED NIP ROLL, ER SLITTING STATION, 10" | 1 |
| 2 | ER-10 | ER 10 BEARING 1.8504 OD X .625 ID | 2 |
| 3 | 16331 | GEAR ,S2050-14-1/2, 5/8 BORE RECESSED | 1 |
| 4 | SSCR-HEX-CUP_.250-20 UNC_0.25_SIMP | SSCR 1/4-20 X 1/4 | 1 |



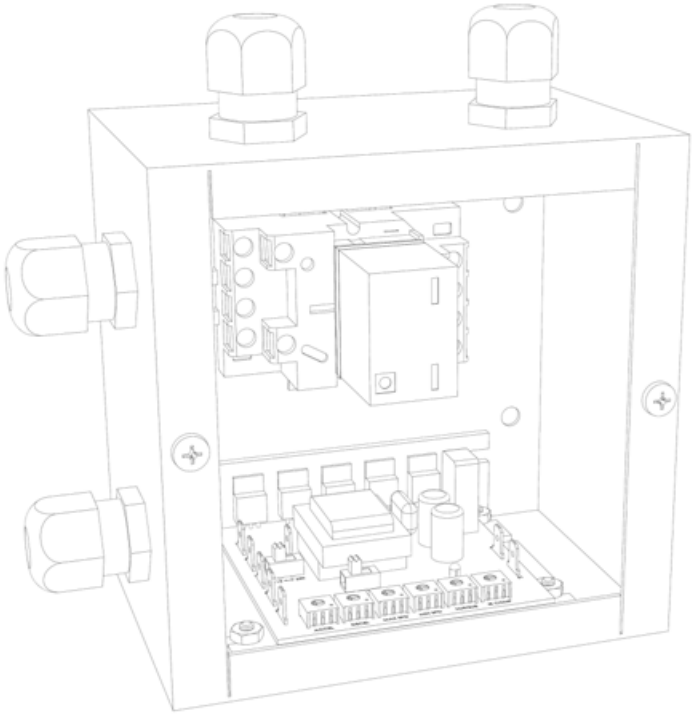
## Electrical Details



20298 Main Enclosure

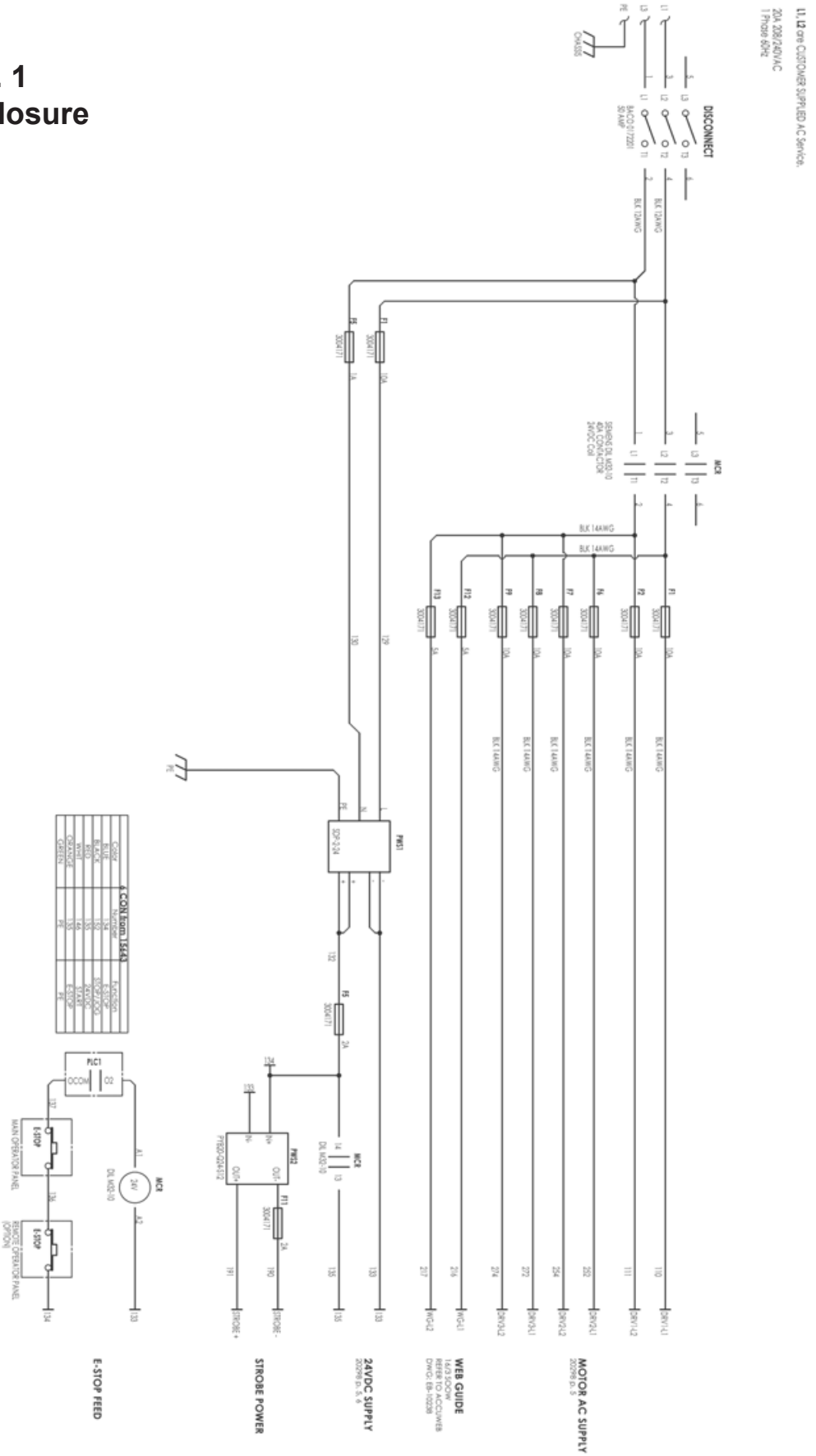


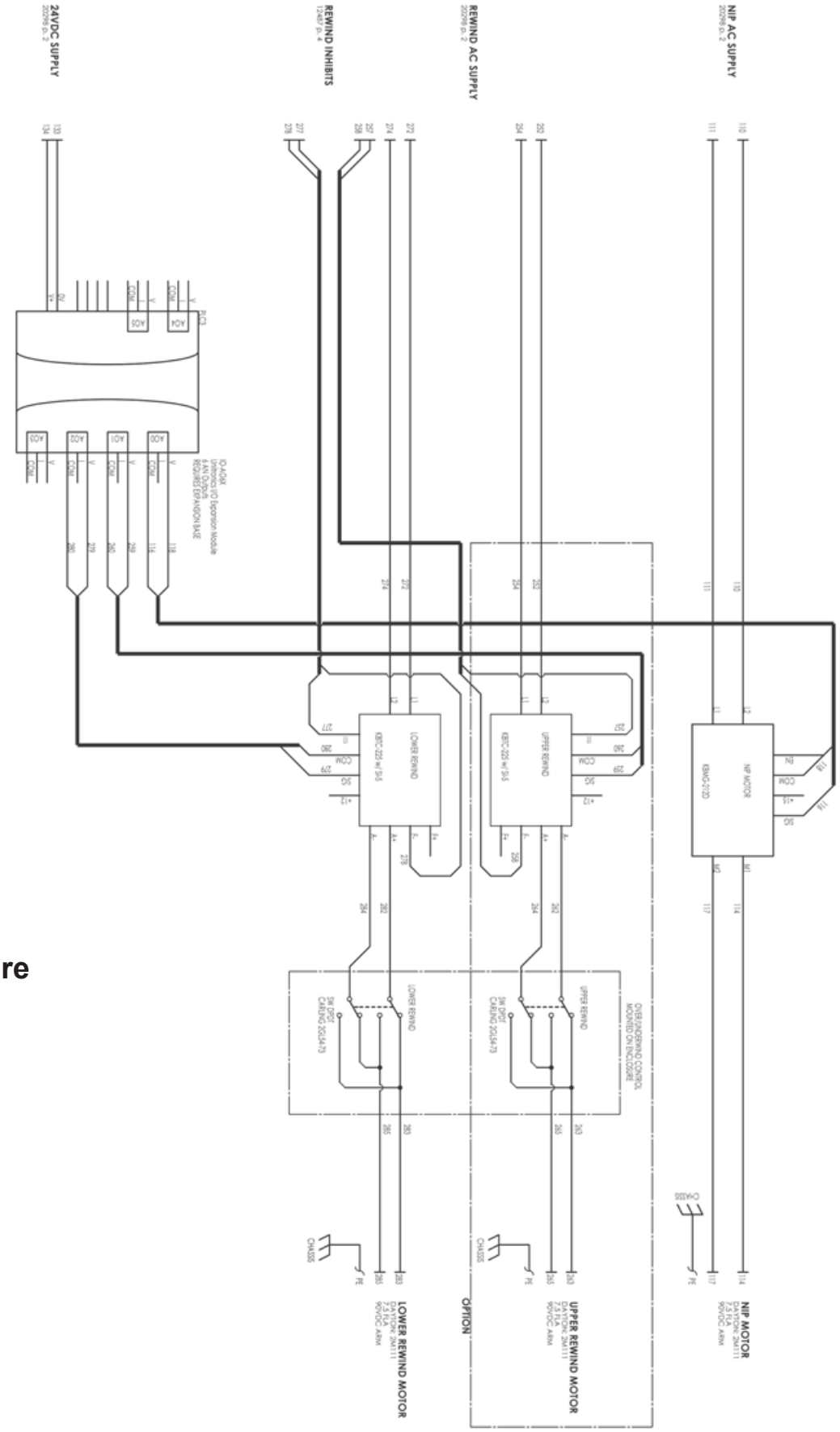
20713 Operator Enclosure



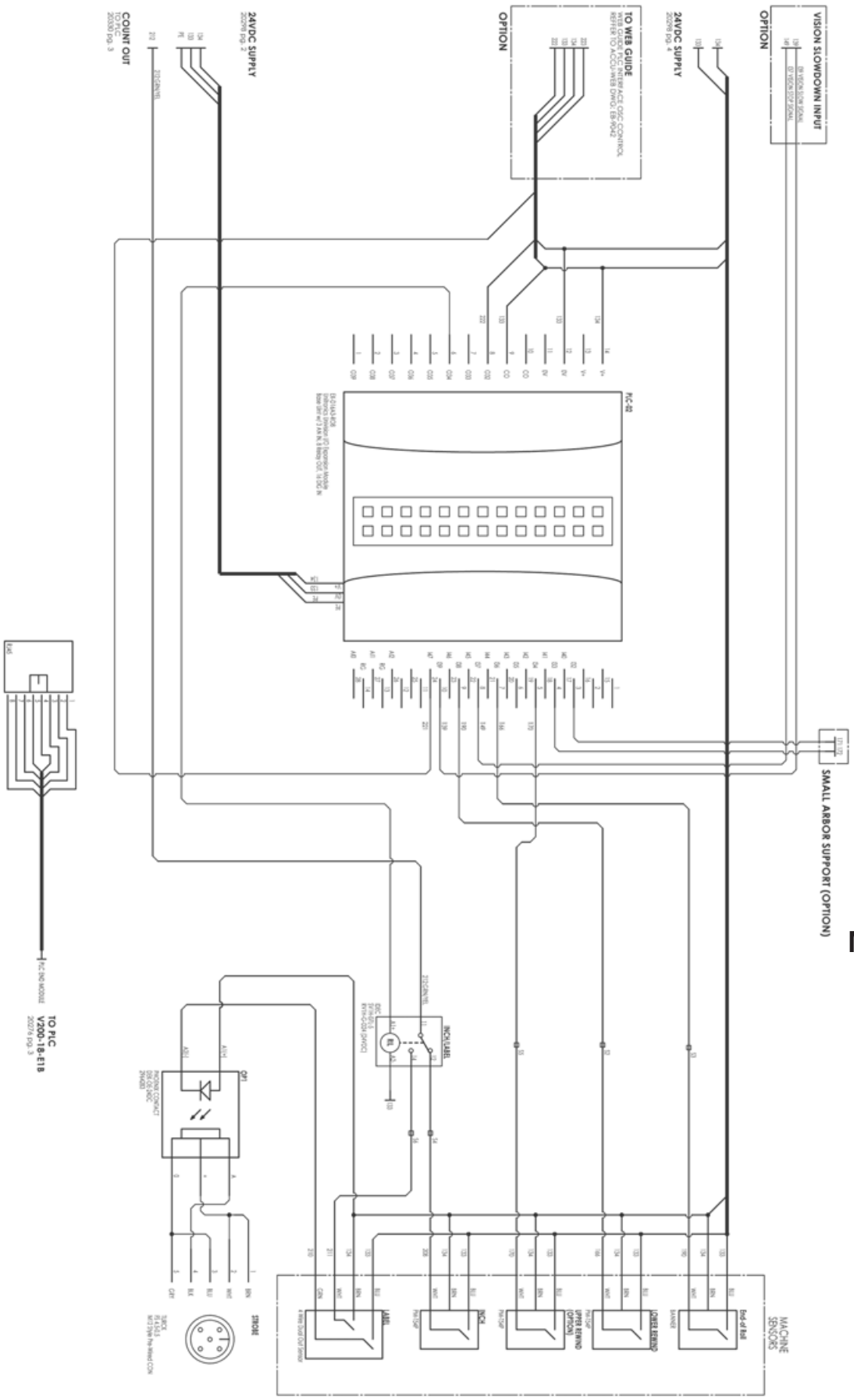
20421 Waste Rewind Enclosure (Option)

## 20298 pg. 1
## Main Enclosure

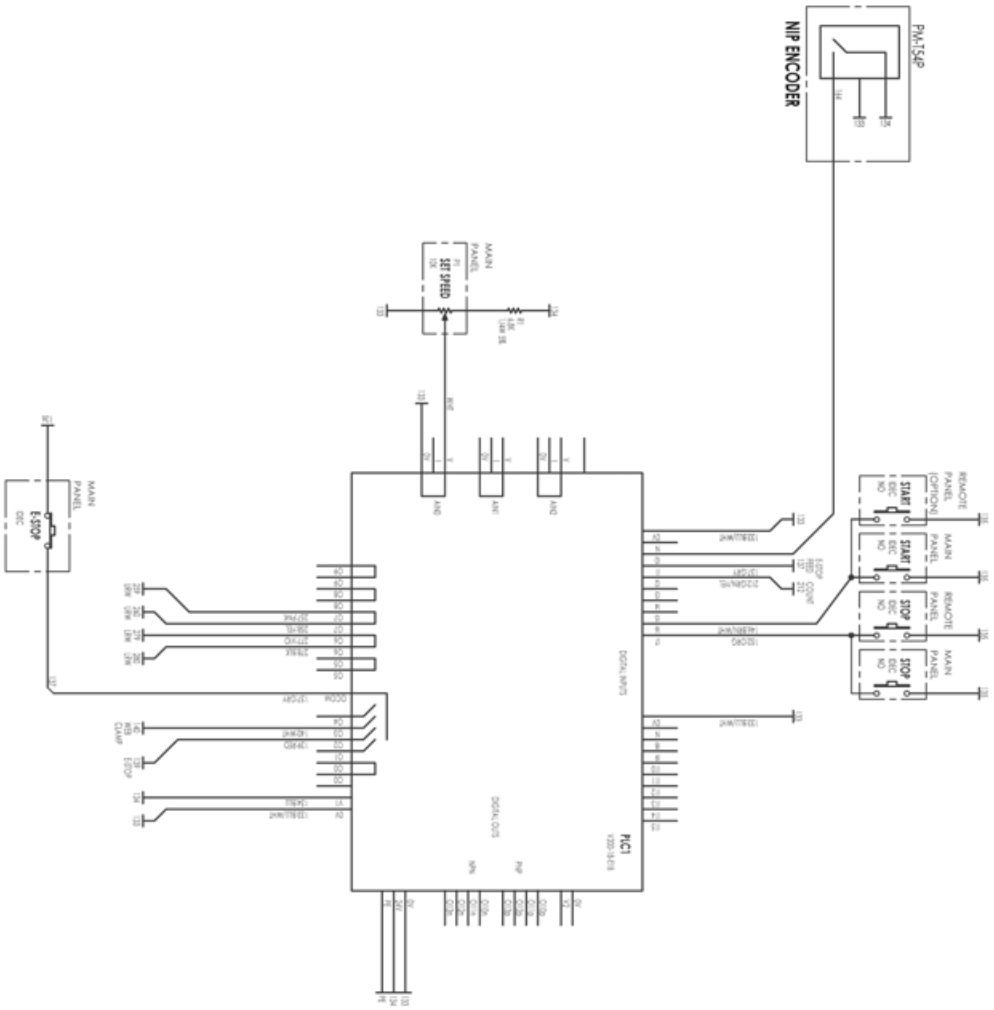





**20298 pg. 2**
**Main Enclosure**

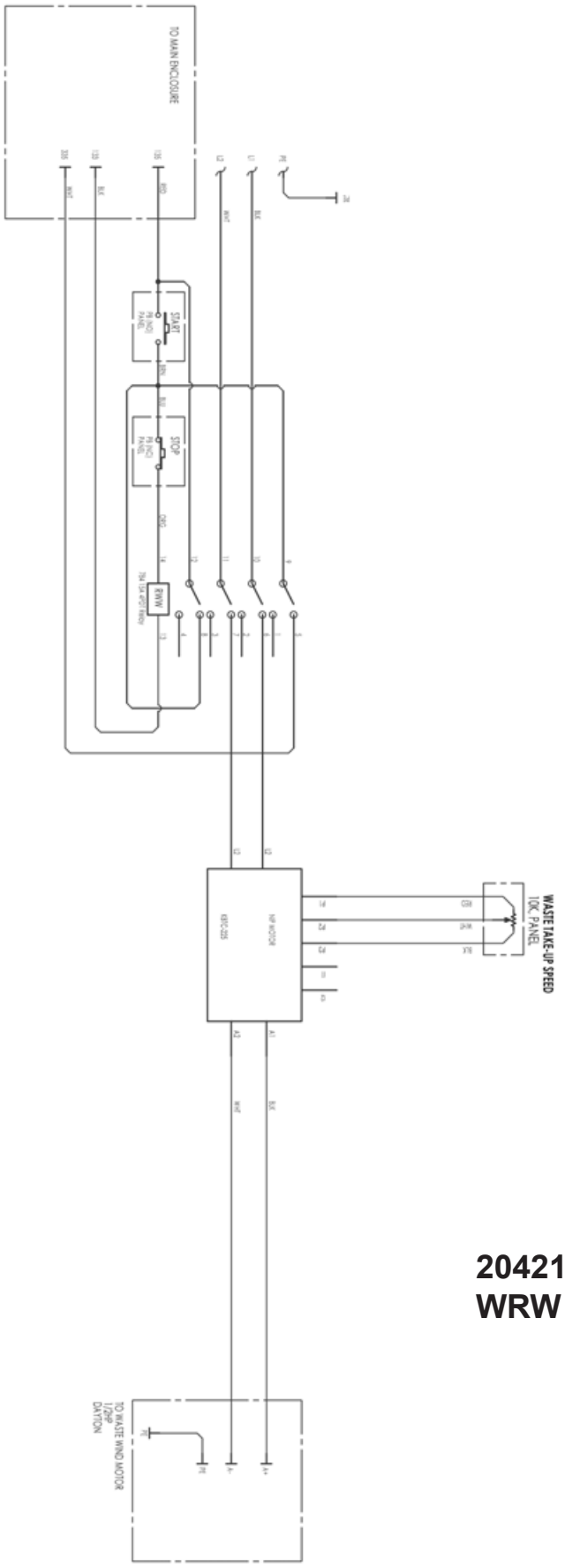



**20298 pg. 3**
**Main Enclosure**



| 14 CON 18AWG from 20298 Panel | | |
|---|---|---|
| Wire Color | Number | Function |
| BLU | 134 | CONST 24VDC |
| BLU/WHT | 133 | DC COMM |
| GRN/WHT | 164 | NIP ENCODER |
| GRN/YEL | 212 | PROCESS COUNT |
| BRN | 136 | E-STOP HIGH |
| BRN/WHT | 146 | START PB |
| BLK | 278 | LRW EN |
| RED | 139 | MCR A1 (COIL) |
| WHT | 140 | WEB CLAMP |
| YEL | 258 | URW EN |
| VIO | 277 | LRW EN |
| GRY | 135 | MCR 24VDC |
| PNK | 257 | URW EN |
| ORG | 152 | STOP |

**20713**
**Operator Enclosure**




**20421**
**WRW Enclosure**

## Section 7: Troubleshooting

**7-1: Why doesn't the machine turn on?**
First check to make sure that the main power switch on the back electrical panel is turned on. Then make sure that the emergency stop button on control panel is disengaged.

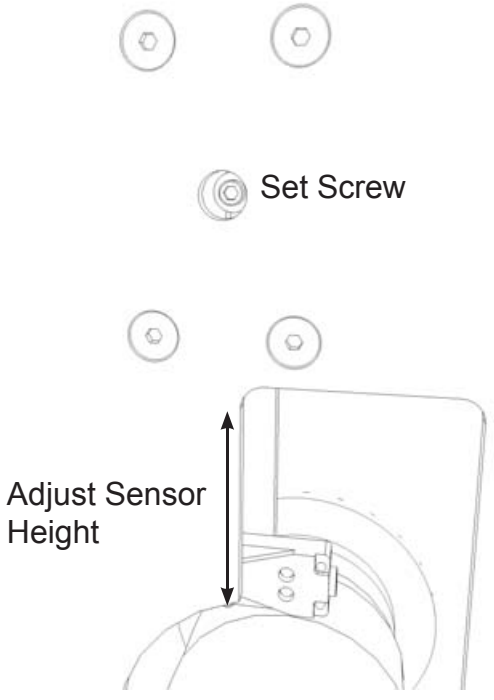
**7-2: The counter is not counting accurately.**
Make sure the counter wheel below the web guide is riding against the idler roller, and is free of dust or debris (see chapter 5) and is not visibly damaged.

**7-3: Why is the counter not counting inches?**
Make sure that the counter sensor below the web guide is flashing red which assures that it is properly connected to the machine. Be sure that the setting on the PLC is "Distance".

**7-4: Why is the counter not counting labels?**
If your machine is equipped with the optional label counter and is not doing so, after assuring that the counter sensor below the web guide is flashing red which assures that it is properly connected, assure that the PLC is set to "LABELS".

**7-5: Why isn't the end-of-roll sensor working?**
If your  is equipped with the optional end-of-roll shut-down and it is not shutting down the machine when the unwind roll is near the end, or if it is shutting down prematurely, perform the following:

1. Assure that the light on the sensor (see figure 7-B) located near the unwind spindle is illuminated.
2. If not illuminated, check wiring for proper connections or damage. If wiring is set up properly, the sensor may need to be replaced.
3. If illuminated, the sensor may be in need of adjustment. If the machine is shutting down prematurely, the sensor needs to be moved closer to the unwind spindle, where if it is not shutting down the machine at all, the sensor needs to be moved away from the unwind spindle. To adjust the sensor, simply loosen the set screw, slide bracket in either direction, and re-tighten.



## Section 8: Warranties and Service

### 8-1: Warranties & Provisions

***WARRANTIES:*** All equipment manufactured and sold by AZTECH Converting Systems (Seller) is warranted to be free of defective materials and workmanship under normal use and service for a period of one (1) year from the date of delivery to Buyer's premises. All commercial components not manufactured by Seller carry the original manufacturer's warranty. At Seller's discretion, Seller may provide on-site warranty service for a period of ninety (90) days from the aforementioned date.

***REMEDIES*** If within the Warranty Period any such Equipment is proven to Seller's satisfaction to be defective in either material or workmanship, Seller, at its sole discretion, shall (a) repair or replace defective parts on the Equipment at Seller's cost, or (b) grant a reasonable allowance on account of such a breach. If within the Warranty Period the Seller receives notice from Buyer of defects in parts or materials. Seller will ship (ground, prepaid) replacement parts) and invoice Buyer for the full cost of the replacement parts). Buyer will receive a Return Authorization (RA) from seller, and return defective parts or materials to Seller, who at its sole discretion shall determine whether defective parts or materials are or are not subject to exclusion from this warranty as provided herein. Any defective parts or material not excluded from the Warranty Period will then be fully credited to Buyer.

***EXCLUSIONS***
**THE FOLLOWING ITEMS ARE EXCLUDED FROM THIS WARRANTY:**

- Defects or damage caused by careless or improper use.
- Parts that need periodic replacement from wear during normal operation.
- Routine maintenance and adjustment.
- Failure or damage caused by improper installation or inadequate maintenance by Buyer.
- Failure or damage caused by equipment modifications by Buyer.
- Equipment damage resulting from an accident, or abnormal conditions of operation.

***DISCLAIMER OR WARRANTY***
**NO OTHER WARRANTY IS EXPRESSED OR IMPLIED INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR ANY PARTICULAR PURPOSE. SELLER IS NOT LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGE SUCH AS, BUT NOT LIMITED TO LOSS IN PROFITS, LOSS OF USE OF EQUIPMENT, OR INCREASED IN OPERATING COSTS OR EXPENSES.**

### 8-2: Technical Service

In the event that your machine is not functioning properly or if you have any technical questions, an AZTECH Technical Service representative is available to assist you. Contact information is as follows:

**Phone:** **1-480-951-8351**
**1-800-829-8351**
**Fax:** **1-480-998-5409**
**E-Mail:** **techservice@aztechconverting.com**